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Printed Name of Person Signing: MARGARET B. KELLEY

Signature of Person Signing: Margaret B. Kelley
ROGERS & WELLS LLP



NSC Docket No. 1477A-3-1
R&W Docket No. 003046-00171

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE
PATENT OPERATION

Assistant Commissioner for Patents
Box Patent Application
Washington, D.C. 20231

Sir:

Transmitted herewith for filing is
the patent application under 37 CFR 1.53(b):

Applicants: Chung-Wai Chiu et al.

For: THERMALLY-INHIBITED NON-PREGELATINIZED GRANULAR
STARCHES AND FLOURS AND PROCESS FOR THEIR PREPARATION

Enclosed are:

- ☒ Specification- 75 pages; 31 Claims- 4 pages; Abstract.
- ☒ Declaration, Power of Attorney, and Petition.
- ☐ Assignment to National Starch and Chemical Company
- ☐ Assignment Recordation Cover Sheet
- ☐ Enclosed is a check in the amount of \$40.00 to cover the Assignment Recordation Fee.
- ☐ Small Entity Status Declaration.
- ☒ Preliminary Amendment – 8 pages with Express Mail Certificate of Mailing.

CLAIMS AS FILED						
AFTER ENTRY OF PRELIMINARY AMENDMENT						
For	Number Filed		Number Extra		Extra	Basic Fee
						\$760.00
Total Claims	42- 20	=	22	x	\$18.00	= \$396.00
Independent Claims	2- 3	=	0	x	\$78.00	= .00
Presentation of multiple dependent claims			0	+	\$260.00	= \$0.00
Total Filing Fee:						<u>\$1156.00</u>

☐ Certified Copy of priority document, claimed herein.

Applicant hereby claims priority under the International Convention and under 35 U.S.C. §119 based upon the following:

Patent Application Serial No. filed

☒ Information Disclosure Statements, PTO-1449 Forms, and References may be found in prior application Ser. No. 593,022 filed January 29, 1996.

☒ **If a continuing application**, check appropriate box

☒ Continuation ☐ Divisional

☐ Continuation-in-part (CIP)


of prior application Ser. No. 593,022 filed January 29, 1996, which is a continuation-in-part of both pending U.S. application Ser. No. 473,688 filed June 7, 1995 and pending U.S. application Ser. No. 374,279 filed January 18, 1995. The '022 application is a continuation-in-part of pending U.S. application Ser. No. 374,279. The '279 application is a continuation-in-part of pending U.S. application Ser. No. 296,211 filed August 25, 1994, which is a continuation-in-part of abandoned U.S. application Ser. No. 099,753 filed July 30, 1993.

☐ A check in the amount of \$ to cover the filing fee and any additional claim fee is enclosed.

X The Commissioner is hereby authorized to charge any additional fees which may required in connection with the filing of this application, or credit any overpayment, to Deposit Account No. 14-0455. A duplicate copy of this sheet is enclosed.

Respectfully submitted,

Dated: June 7, 1999


Margaret B. Kelley
Reg. No. 29,181

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ROGERS & WELLS LLP

NSC Docket No. 1477A-3-1

R&W Docket No. 3046-171

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re Application of : CHUNG-WAI CHIU et al.
U.S. Serial No. : To Be Assigned
Filing Date : Herewith
For : THERMALLY-INHIBITED, NON-PREGELATINIZED
GRANULAR STARCHES AND FLOURS AND
PROCESS FOR THEIR PREPARATION
Examiner : To be assigned (former Examiner Lynn Hailey)
Group Art Unit : To be assigned (former Art Unit 1755)

Assistant Commissioner for Patents
Washington, D.C. 20231

PRELIMINARY AMENDMENT

Sirs:

Please amend the above-identified continuation application as follows:

In The Title:

Add a comma after "THERMALLY-INHIBITED"

In The Specification:

On page 1, at line 5, after the word "is" insert - - a continuation of allowed U.S. application Ser. No. 08/593,022 filed January 29, 1996, which is - -

In The Claims:

Please cancel pending Claims 1-11 and 36-60. Claim 61 was cancelled by an Examiner's Amendment in the allowed '022 application. Please add new Claims 62-103 as follows:

62. A process for making a thermally-inhibited, non-pregelatinized granular starch or flour, which comprises the steps of:

(a) thermally and/or non-thermally dehydrating a non-pregelatinized granular starch or flour to anhydrous or substantially anhydrous; and

(b) heat treating the anhydrous or substantially anhydrous starch or flour at a temperature of about 120°C to about 180°C for up to 20 hours.

63. The process of Claim 62, wherein the substantially anhydrous granular starch or flour has a moisture content of less than 1 wt. %.

64. The process of Claim 62, wherein the thermal dehydrating step is carried out at a temperature of about 120° to about 160°C.

65. The process of Claim 64, wherein the non-thermal dehydrating step is carried out by extracting the granular starch or flour with a solvent or by freeze drying the granular starch flour.

66. The process of Claim 65, wherein the solvent is a hydrophilic solvent.

67. The process of Claim 66, wherein the hydrophilic solvent forms an azeotrope with water.

68. The process of Claim 67, wherein the solvent is an alcohol.

69. The process of Claim 62, wherein the dehydrating step is a thermal dehydrating step and wherein the thermal dehydrating and heat treating steps are carried out simultaneously in a fluidized bed.

70. The process of Claim 72, wherein the steps are carried out for up to about 5 hours.

71. The process of Claim 62, further comprising the step of extracting the heat-treated starch or flour with an organic solvent to improve the flavor and/or color of the starch or flour.

72. The process of Claim 75, wherein the solvent is ethanol.

73. The process of Claim 62, further comprising the step of washing the starch or flour with water prior to the dehydrating step and/or after the heat treating step.

74. The process of Claim 62, further comprising the step of removing protein and/or lipid from the starch or flour prior to the dehydrating step and/or after the heat treating step.

75. The process of Claim 74, wherein a bleaching agent is used to remove the protein and/or lipid.

76. The process of Claim 75, wherein the bleaching agent is sodium chlorite.

77. The process of Claim 74, wherein an alkali is used to remove the protein and/or lipid.

78. The process of Claim 62, wherein the granular starch or flour is a cereal, root, tuber, legume, or fruit starch or flour.

79. The process of Claim 78, wherein the granular starch is selected from the group consisting of banana, corn, pea, potato, sweet potato, barley, wheat, rice, sago, amaranth, tapioca, sorghum, V.O. hybrid waxy maize, waxy maize, waxy rice, waxy barley, waxy potato, waxy sorghum, and a granular starch or flour containing greater than 40% amylose.

80. The process of Claim 79, wherein the starch is a waxy starch, a potato starch, a tapioca starch, or a rice starch.

81. The process of Claim 80, wherein the waxy starch is a waxy maize.

82. A process for making a thermally-inhibited, non-pregelatinized granular starch or flour, which comprises the steps of:

(a) adjusting the pH of a non-pregelatinized granular starch or flour to neutral or greater;

(b) thermally and/or non-thermally dehydrating the pH adjusted, non-pregelatinized granular starch or flour to anhydrous or substantially anhydrous; and

(c) heat treating the anhydrous or substantially anhydrous starch or flour at a temperature of about 120°C to about 160°C for up to 20 hours.

83. The process of Claim 82, wherein the pH is about 7 to about 9.5.

84. The process of Claim 83, wherein the pH is about 8 to about 9.5.

85. The process of Claim 82, wherein the substantially anhydrous granular starch or flour has a moisture content of less than 1 wt. %.

86. The process of Claim 82, wherein the thermal dehydrating step is carried out at a temperature of about 120° to about 160°C.

87. The process of Claim 82, wherein the non-thermal dehydrating step is carried out by extracting the granular starch or flour with a solvent or by freeze drying the granular starch flour.

88. The process of Claim 87, wherein the solvent is a hydrophilic solvent.

89. The process of Claim 88, wherein the hydrophilic solvent forms an azeotrope with water.

90. The process of Claim 89, wherein the solvent is an alcohol.

91. The process of Claim 82, wherein the dehydrating step is a thermal dehydrating step and wherein the thermal dehydrating and the heat treating steps are carried out simultaneously in a fluidized bed.

92. The process of Claim 91, wherein the steps are carried out for up to about 5 hours.

93. The process of Claim 82, further comprising the step of extracting the heat-treated starch or flour with an organic solvent to improve the flavor and/or color of the starch or flour.

94. The process of Claim 93, wherein the solvent is ethanol.

95. The process of Claim 82, further comprising the step of washing the starch or flour with water prior to the dehydrating step and/or after the heat treating step.

96. The process of Claim 82, further comprising the step of removing protein and/or lipid from the starch or flour prior to the dehydrating step and/or after the heat treating step.

97. The process of Claim 96, wherein a bleaching agent is used to remove the protein and/or lipid.

98. The process of Claim 97, wherein the bleaching agent is sodium chlorite.

99. The process of Claim 96, wherein an alkali is used to remove the protein and/or lipid.

100. The process of Claim 82, wherein the granular starch or flour is a cereal, root, tuber, legume, or fruit starch or flour.

101. The process of Claim 100, wherein the granular starch is selected from the group consisting of banana, corn, pea, potato, sweet potato, barley, wheat, rice, sago, amaranth, tapioca, sorghum, V.O. hybrid waxy maize, waxy maize, waxy rice, waxy barley, waxy potato, waxy sorghum, and a granular process or flour containing greater than 40% amylose.

102. The process of Claim 101, wherein starch is a waxy, a potato, a tapioca, or a rice starch.

103. The process of Claim 102, wherein the waxy starch is a waxy maize.

Remarks

The claims are fully supported in the original specification and claims.

See original Claim 13 for the dehydrating and heat treating steps and original Claim 20 for the temperature of 100°C or greater.

See original Claim 22 for the step of adjusting the pH to neutral or greater prior to the dehydrating step. See original Claim 23 for a pH of about 7-9.5 and the disclosure at page 12, lines 20-22 for a pH of about 8-9.5. The relevant text reads: "A pH of at least 7 is preferred. More preferably, the pH is 7.5 – 10.5. The most preferred pH range is above 8 to below 10". See also the examples, specifically page 35, lines 25-30 for pH values of 8.5 and 9.5

See original Claim 14 for thermal and/or non-thermal dehydrating. See original Claim 15 for non-thermal dehydration by solvent extracting or by freeze drying, original Claim 16 for the use of hydrophilic solvent, original Claim 18 for the use of a hydrophilic solvent which forms an azeotrope with water, and original Claim 19 for an alcohol as the azeotropic solvent.

See original Claim 21 for the heating temperature of about 120-180°C and heating time of up to about 20 hours. See the disclosure at page 15, lines 13-15 for the heating time of up to 5 hours. The relevant text reads "...the time ranges from 1 to 20 hours, typically 2 to 5 hours, usually 3.5 to 4.5 hours.

See original Claim 31 for the simultaneous dehydrating and heat treating in a fluidized bed.

See original Claim 5 for the general starch classes and original Claim 6 for the specific starches.

See original Claim 24 for the additional step of extracting the heat-treated starch with an organic solvent to improve the flavor and/or color. See original Claim 24 for the use of ethanol as the organic solvent to effect the flavor and/or color improvement.

See original Claim 26 for the washing step and original Claims 27-30 for the protein and/or lipid removal step.

No new matter is presented. Entry of the amendment is respectfully requested.

Respectfully submitted,

Date: June 7, 1999

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THERMALLY-INHIBITED NON-PREGELATINIZED GRANULAR
STARCHES AND FLOURS AND PROCESS FOR THEIR PREPARATION

5 This application is a continuation-in-part of both
pending U.S. application Ser. No. 473,688 filed June 7, 1995
and pending U.S. application Ser. No. 374,279 filed January
18, 1995. The '279 application is a continuation-in-part of
10 pending U.S. application Ser. No. 296,211 filed August 25,
1994, which is a continuation-in-part of abandoned U.S.
application Ser. No. 099,753 filed July 30, 1993.

FIELD OF THE INVENTION

15 This invention relates to starches and flours that
are inhibited and to a process for their preparation. The
inhibited starches and flours may be used in place of the
chemically crosslinked (i.e., chemically inhibited) starches
and flours presently used in foods and in the manufacture of
industrial products.

20

BACKGROUND OF THE INVENTION

Heat Treatment of Starches and Flours

Heat/moisture treatment and annealing of starches
and/or flours are taught in the literature and distinguished
25 by the amount of water present. "Annealing" involves

slurrying a granular starch with excess water at temperatures below the starch's or flour's gelatinization temperature. "Heat/moisture-treatment" involves a semi-dry treatment at temperatures below the starch's or flour's
5 gelatinization temperature, with no added moisture and with the only moisture present being that normally present in a starch granule (which is typically 10% or more).

In the following discussion, a history of the various heat/moisture and annealing treatments of starch
10 and/or flour is set out.

GB 263,897 (accepted Dec. 24, 1926) discloses an improvement in the heat treatment process of GB 228,829. The process of the '829 patent involves dry heating flour or wheat to a point at which substantially all of the gluten is
15 rendered non-retainable in a washing test and then blending the treated flour or wheat with untreated flour or wheat to provide a blend having superior strength. The improvement of the '897 patent is continuing the dry heating, without, however, gelatinizing the starch, for a considerable time
20 beyond that necessary to render all of the gluten non-retainable. "Dry-heating" excludes heating in a steam atmosphere or an atmosphere containing considerable quantities of water vapor which would tend to gelatinize the starch. The wheat or flour may contain the usual amount of
25 moisture, preferably not greater than 15%. The heat treatment may exceed 7 hours at 77-93°C (170-200°F), e.g., 8 to 14 hours at 82°C (180°F) or 6 hours at 100°C (212°F).

GB 530,226 (accepted Dec. 6, 1940) discloses a method for drying a starch cake containing about 40-50%
30 water with hot air or another gas at 149°C (300°F) or above without gelatinizing the starch. The starch cake is disintegrated by milling it to a finely divided state prior to drying.

GB-595,552 (accepted December 9, 1947) discloses treatment of starch, more particularly a corn starch, which involves drying the starch to a relatively low moisture content of 1-2%, not exceeding 3%, and subsequently dry heating the substantially moisture-free starch at 115-126°C for 1 to 3 hours. The treatment is intended to render the starch free from thermophilic bacteria. The starch should not be heated longer than necessary to effect the desired sterilization.

U.S. 3,490,917 (issued January 20, 1970 to C.A.F. Doe et al.) discloses a process for preparing a non-chlorinated cake flour suitable for use in cakes and sponges having a high sugar to flour ratio. The starch or a flour in which the gluten is substantially or completely detached from the starch granules is heated to a temperature of from 100-140°C and then cooled. The conditions are selected so that dextrinization does not occur, e.g., about 15 minutes at 100-115°C and no hold and rapid cooling at the higher temperatures. The heat treatment should be carried out under conditions which allow the water vapor to escape. The reduction in moisture content due to the heat treatment depends upon the temperature employed. At treatment temperatures of 100-105°C, the moisture content is reduced from 10-12% to 8-9%, by weight, while at medium and high temperatures the moisture content is typically reduced to 7% or less. Preferably, during cooling the moisture is allowed to reach moisture equilibrium with the atmosphere. The gelatinization temperature of the heat treated starch or flour is approximately 0.5-1°C higher than that of a comparable chlorinated flour or starch. The heating can be carried out in many ways, including heating in a hot air fluidized bed.

U.S. 3,578,497 (issued May 11, 1971 to E. T. Hjermstad) discloses a process for non-chemically improving the paste and gel properties of potato starch and imparting a swelling temperature as much as -7 to -1°C (20 to 30°F) higher. A concentrated suspension (20-40% dry solids) at a neutral pH (5.5-8.0, preferably 6-7.5) is heated either for a long time at a relatively low temperature or for a short time at successively higher temperatures. The suspension is first heated at a temperature below the incipient swelling temperature of the particular batch of starch being treated (preferably 49°C - 120°F). Then the temperature is gradually raised until a temperature well above the original swelling temperature is attained. It is essential that swelling be avoided during the different heating periods so that gelatinization does not occur. After this steeping treatment the starch has a higher degree of granular stability. It resists rapid gelatinization and produces a rising or fairly flat viscosity curve on cooling. The pastes are very short textured, non-gumming, non-slimy, cloudy and non-cohesive. They form firm gels on cooling and aging.

U.S. 3,977,897 (issued August 31, 1976 to Wurzburg et al.) discloses a method for preparing non-chemically inhibited amylose-containing starches. Both cereal and root starches can be inhibited, but the inhibition effects are more observable with root starches. Amylose-free starches, such as waxy corn starch, show no or very slight inhibition. The Brabender viscosity of cooked pastes derived from the treated starch was used to determine the inhibition level. Inhibition was indicated by a delayed peak time in the case of the treated corn starch, by the lack of a peak and a higher final viscosity in the case of the treated achira starch, and by the loss of cohesiveness in the case of the

5 treated tapioca starch. The granular starch is suspended in
water in the presence of salts which raise the starch's
gelatinization temperature so that the suspension may be
heated to high temperatures without causing the starch
granules to swell and rupture yielding a gelatinized
product. The preferred salts are sodium, ammonium,
magnesium or potassium sulfate; sodium, potassium or
ammonium chloride; and sodium, potassium or ammonium
phosphate. About 10-60 parts of salt are used per 100 parts
by weight of starch. Preferably, about 110 to 220 parts of
water are used per 100 parts by weight of starch. The
suspension is heated at 50-100°C, preferably 60-90°C, for
about 0.5 to 30 hours. The pH of the suspension is
maintained at about 3-9, preferably 4-7. Highly alkaline
systems, i.e., pH levels above 9 retard inhibition.

U.S. 4,013,799 (issued March 22, 1977, to
Smalligan et al.) discloses heating a tapioca starch above
its gelatinization temperature with insufficient moisture
(15 to 35% by total weight) to produce gelatinization. The
starch is heated to 70-130°C for 1 to 72 hours. The starch
is used as a thickener in wet, pre-cooked baby foods having
a pH below about 4.5.

U.S. 4,303,451 (issued December 1, 1981 to Seidel
et al.) discloses a method for preparing a pregelatinized
waxy maize starch having improved flavor characteristics
reminiscent of a tapioca starch. The starch is heat treated
at 120-200°C for 15 to 20 minutes. The pregelatinized
starch has gel strength and viscosity characteristics
suitable for use in pudding mixes.

U.S. 4,303,452 (issued Dec. 1, 1981 to Ohira et
al.) discloses smoking a waxy maize starch to improve gel
strength and impart a smoky taste. In order to counteract
the smoke's acidity and to obtain a final product with a pH

of 4-7, the pH of the starch is raised to pH 9-11 before smoking. The preferred water content of the starch during smoking is 10-20%

The article "Differential Scanning Calorimetry of Heat-Moisture Treated Wheat and Potato Starches" by J.W. Donovan et al. in Cereal Chemistry, Vol. 60, No. 5, pp. 381-387 (1983) discloses that the gelatinization temperature of the starches increased as a result of the heat/moisture treatment or annealing. See also the article "A DSC Study Of The Effect Annealing On Gelatinization Behavior Of Corn Starch" by B.R. Krueger et al. in Journal of Food Science, Vol. 52, No. 3, pp. 715-718 (1987).

U.S. 4,391,836 (issued July 5, 1983 to C.-W. Chiu) discloses instant gelling tapioca and potato starches which are non-granular and which have a reduced viscosity. Unmodified potato and tapioca starches do not normally gel. The starches of the patent are rendered non-granular and cold-water-dispersible by forming an aqueous slurry of the native starch at a pH of about 5-12 and then drum-drying the slurry. The starches are rendered gelling by heat treating the drum-dried starch for about 1.5 to 24 hours at 125-180°C to reduce the viscosity to within defined Brabender viscosity limitations.

U.S. 4,491,483 (issued January 1, 1985 to W.E. Dudacek et al.) discloses subjecting a semi-moist blend of a granular starch with at least 0.25 wt. % of a fatty acid surfactant and sufficient water (about 10-40 wt. %) to a heat-moisture treatment at from about 50-120°C, followed by drying to about 5-15 wt. %, preferably 10 wt. %, moisture. The heat-moisture treated starch-surfactant product is characterized by a hot water dispersibility of from about 60-100% and a higher pasting temperature than the granular starch from which it is derived. Preferably, the treatment

takes place in a closed container so that the moisture can be maintained at a constant level. The preferred conditions are 3 to 16 hours at 60-90°C. Degradation and dextrinization reactions are undesirable as they destroy the thickening ability of the starch. The use of conditions, such as, e.g., 35% moisture at 90°C for 16 hours results in reduced paste viscosity. It is believed the presence of the surfactant during the treatment permits formation of a complex within the partially swollen starch matrix with straight chain portions of the starch molecules. The limited moisture environment allows complex formation without gelatinization.

Japanese Patent Publication No. 61-254602, (published December 11, 1987) discloses a wet and dry method for heating waxy corn starch and derivatives thereof to impart emulsification properties. The wet or dry starch is heated at 100-200°C, preferably 130-150°C, for 0.5 to 6 hours. In the dry method, the water content is 10%, preferably 5%, or less. In the wet method, the water content is 5 to 50%, preferably 20-30%. The pH is 3.5-8, preferably 4-5.

The article "Hydrothermal Modification of Starches: The Difference between Annealing and Heat/Moisture-Treatment", by Rolf Stute, Starch/Stärke Vol. 44, No. 6, pp. 205-214 (1992) reports almost identical modifications in the properties of potato starch with annealing and heat/moisture treatments even though the alteration of the granular structure is different. The Brabender curves of the heat/moisture-treated and annealed potato starches show the same typical changes, including a higher gelatinization temperature and a lower peak viscosity or no peak. The DSC curves also show a shift to higher gelatinization temperatures for both treatments. A combined

treatment involving annealing a heat/moisture-treated potato starch leads to a further increase in gelatinization temperature without detectable changes in gelatinization enthalpy and with retention of the viscosity changes caused by the heat treatment. A combined treatment involving annealing a heat/moisture-treated potato starch does not lower the gelatinization temperature, when compared to the base starch, and increases the gelatinization temperature at higher heat/moisture treatment levels.

10 Chemical Crosslinking of Starches And Flours

Starches are chemically modified with difunctional reagents, such as phosphorus oxychloride, sodium trimetaphosphate, adipic anhydride, acetic anhydride and epichlorohydrin, to produce chemically crosslinked starches having excellent tolerance to processing variables such as heat, shear, and pH extremes. Such chemically crosslinked (also referred to as "inhibited" starches) provide a desirable smooth texture and possess viscosity stability throughout the processing operation and normal shelf life.

20 In contrast, unmodified (i.e., non-crosslinked) starches breakdown in viscosity, loose thickening capacity and textural qualities, and behave unpredictably during storage as a result of the stresses encountered during processing. Heat, shear, and/or an extreme pH, especially an acidic pH, tend to fully disrupt the starch granules and disperse the starch.

When native starch granules are dispersed in water and heated, they become hydrated and swell at about 60°C, and reach a peak viscosity through the 65°-95°C range. This increase in viscosity is a desired property in many food and industrial applications and results from the physical force or friction between the highly swollen granules. Swollen, hydrated starch granules, however, are quite fragile. As

the starch slurry is held at temperatures of 92°-95°C, the starch granules begin to fragment and the viscosity breaks down. Shear or conditions of extreme pH also tend to disrupt and fragment the granules, so that the starch
5 polymers dissociate and become solubilized, leading to a rapid breakdown from the initially high viscosity.

It has been known that both the swelling of the starch granules and the breakdown in viscosity can be inhibited by treating the starch with chemical reagents that
10 introduce intermolecular bridges or crosslinks between the starch molecules. The crosslinks reinforce the associative hydrogen bonds holding the granules together, restrict the swelling of the starch granules, and consequently inhibit disruption and fragmentation of the granules. Because of
15 this inhibition, crosslinked starches are also called inhibited starches.

Because chemically crosslinked starches are used in many applications where a stable-viscosity starch paste is needed, it would be an advantage in cost, time, and in
20 the reduction of the use of chemicals, if native or modified starch could be inhibited to perform the same as chemically crosslinked starch without the use of chemicals.

SUMMARY OF THE INVENTION

25 Non-pregelatinized starches and flours are thermally inhibited, without the addition of chemical reagents, in a heat treatment process that results in the starch or flour becoming and remaining inhibited. The starches and flours are referred to as "inhibited" or
30 "thermally-inhibited (abbreviated "T-I"). When these thermally-inhibited starches and flours are dispersed and/or cooked in water, they exhibit the textural and viscosity properties characteristic of a chemically-crosslinked

starch. The starch granules are more resistant to viscosity breakdown. This resistance to breakdown results in what is subjectively considered a non-cohesive or "short" textured paste, meaning that the gelatinized starch or flour tends to be salve-like and heavy in viscosity rather than runny or gummy.

The non-pregelatinized thermally-inhibited granular starches and flours exhibit an unchanged or reduced gelatinization temperature. In contrast, most annealed and heat/moisture treated starches show an increased gelatinization temperature. Chemically-crosslinked starches show an unchanged gelatinization temperature. It is believed the overall granular structure of the thermally-inhibited starches and flours has been altered.

The starches and flours that are substantially completely thermally inhibited will resist gelatinization. The starches and flours that are highly inhibited will gelatinize to a limited extent and show a continuing rise in viscosity but will not attain a peak viscosity. The starches and flours that are moderately inhibited will exhibit a lower peak viscosity and a lower percentage breakdown in viscosity compared to the same starch that is not inhibited. The starches and flours that are lightly inhibited will show a slight increase in peak viscosity and a lower percentage breakdown in viscosity compared to the same starch that is not inhibited.

The starches and flours are inhibited by a process which comprises the steps of dehydrating the starch or flour until it is anhydrous or substantially anhydrous and then heat treating the anhydrous or substantially anhydrous starch or flour at a temperature and for a period of time sufficient to inhibit the starch or flour. As used herein, "substantially anhydrous" means containing less than 1%

moisture by weight. The dehydration may be a thermal dehydration or a non-thermal dehydration such as alcohol extraction or freeze drying. An optional, but preferred, step is adjusting the pH of the starch or flour to neutral or greater prior to the dehydration step.

Depending on the extent of the heat treatment, various levels of inhibition can be achieved. For example, lightly inhibited, higher viscosity products with little breakdown, as well as highly inhibited, low viscosity products with no breakdown, can be prepared by the thermal inhibition processes described herein.

Description of The Preferred Embodiments

All starches and flours are suitable for use herein. The thermally-inhibited starches and flours can be derived from any native source. A "native" starch or flour is one as it is found in nature in unmodified form. Typical sources for the starches and flours are cereals, tubers, roots, legumes and fruits. The native source can be corn, pea, potato, sweet potato, banana, barley, wheat, rice, sago, amaranth, tapioca, sorghum, waxy maize, waxy pea, waxy wheat, waxy tapioca, waxy rice, waxy barley, waxy potato, waxy sorghum, starches having an amylose content of 40% or greater and the like. Preferred starches the are waxy starches, potato, tapioca and corn (including waxy maize, waxy tapioca, waxy rice, waxy potato, waxy sorghum, and waxy barley.

The thermal inhibition process may be carried out prior to or after other starch or flour reactions used to modify starch or flour. The starches may be modified by conversion (i.e., acid-, enzyme-, and/or heat-conversion), oxidation, phosphorylation, etherification (e.g., by reaction with propylene oxide), esterification (e.g., by reaction with acetic anhydride or octenylsuccinic

anhydride), and/or chemical crosslinking (e.g., by reaction with phosphorus oxychloride or sodium trimetaphosphate). The flours may be modified by bleaching or enzyme conversion. Procedures for modifying starches are described in the Chapter "Starch and Its Modification" by M.W. Rutenberg, pages 22-26 to 22-47, Handbook of Water Soluble Gums and Resins, R.L. Davidson, Editor (McGraw-Hill, Inc., New York, NY 1980).

Native granular starches have a natural pH of about 5.0-6.5. When such starches are heated to temperatures above about 125°C in the presence of water, acid hydrolysis (i.e., degradation) of the starch occurs. This degradation impedes or prevents inhibition. Therefore, the dehydration conditions need to be chosen so that degradation is avoided. Suitable conditions are dehydrating at low temperatures and the starch's natural pH or dehydrating at higher temperatures after increasing the pH of the starch to neutral or above. As used herein, "neutral" covers the range of pH values around pH 7 and is meant to include from about pH 6.5-7.5. A pH of at least 7 is preferred. More preferably, the pH is 7.5-10.5. The most preferred pH range is above 8 to below 10. At a pH above 12, gelatinization more easily occurs. Therefore, pH adjustments below 12 are more effective. It should be noted that the textural and viscosity benefits of the thermal inhibition process tend to be enhanced as the pH is increased, although higher pHs tend to increase browning of the starch or flour during the heat treating step.

To adjust the pH, the non-pregelatinized granular starch or flour is typically slurried in water or another aqueous medium, in a ratio of 1.5 to 2.0 parts of water to 1.0 part of starch or flour, and the pH is raised by the addition of any suitable base. Buffers, such as sodium

phosphate, may be used to maintain the pH if needed. Alternatively, a solution of a base may be sprayed onto the powdered starch or flour until the starch or flour attains the desired pH, or an alkaline gas such as ammonia can be
5 infused into the starch or flour. After the pH adjustment, the slurry is then either dewatered and dried, or dried directly, typically to a 2-15% moisture content. These drying procedures are to be distinguished from the thermal inhibition process steps in which the starch or flour is
10 dehydrated to anhydrous or substantially anhydrous and then heat treated.

Suitable bases for use in the pH adjustment step include, but are not limited to, sodium hydroxide, sodium carbonate, tetrasodium pyrophosphate, ammonium
15 orthophosphate, disodium orthophosphate, trisodium phosphate, calcium carbonate, calcium hydroxide, potassium carbonate, and potassium hydroxide, and any other bases approved for use under the applicable regulatory laws. The preferred base is sodium carbonate. It may be possible to
20 use bases not approved provided they can be washed from the starch or flour so that the final product conforms to good manufacturing practices for the desired end use.

A thermal dehydration is carried out by heating the starch or flour in a heating device for a time and at a
25 temperature sufficient to reduce the moisture content to less than 1%, preferably 0%. Preferably, the temperatures used are 125°C or less, more preferably 100-120°C. The dehydrating temperature can be lower than 100°C, but a temperature of at least 100°C will be more efficient for
30 removing moisture.

Representative processes for carrying out a non-thermal dehydration include freeze drying or extracting the water from the starch or flour using a solvent, preferably a

hydrophilic solvent, more preferably a hydrophilic solvent which forms an azeotropic mixture with water (e.g., ethanol).

For a laboratory scale dehydration with a solvent, the starch or flour (about 4-5% moisture) is placed in a Soxhlet thimble which is then placed in a Soxhlet apparatus. A suitable solvent is placed in the apparatus, heated to its reflux temperature, and refluxed for a time sufficient to dehydrate the starch or flour. Since during the refluxing the solvent is condensed onto the starch or flour, the starch or flour is exposed to a lower temperature than the solvent's boiling point. For example, during ethanol extraction the temperature of the starch is only about 40-50°C even though ethanol's boiling point is about 78°C. When ethanol is used as the solvent, the refluxing is continued for about 17 hours. The extracted starch or flour is removed from the thimble, spread out on a tray, and the excess solvent is allowed to flash off. The time required for ethanol to flash off is about 20-30 minutes. The dehydrated starch or flour is immediately placed in a suitable heating apparatus for the heat treatment. For a commercial scale dehydration any continuous extraction apparatus is suitable.

For dehydration by freeze drying, the starch or flour (4-5% moisture) is placed on a tray and put into a freeze dryer. A suitable bulk tray freeze dryer is available from FTS Systems of Stone Ridge, New York under the trademark Dura-Tap. The freeze dryer is run through a programmed cycle to remove the moisture. The temperature is held constant at about 20°C and a vacuum is drawn to about 50 milliTorr (mT). The starch or flour is removed from the freeze dryer and immediately placed into a suitable heating apparatus for the heat treatment.

After it is dehydrated, the starch or flour is heat treated for a time and at a temperature sufficient to inhibit the starch or flour. The preferred heating temperatures are greater than about 100°C. For practical purposes, the upper limit of the heat treating temperature is about 200°C. Typical temperatures are 120-180°C, preferably 140-160°C, most preferably 160°C. The temperature selected will depend upon the amount of inhibition desired and the rate at which it is to be achieved.

The time at the final heating temperature will depend upon the level of inhibition desired. When a conventional oven is used, the time ranges from 1 to 20 hours, typically 2 to 5 hours, usually 3.5 to 4.5 hours. When a fluidized bed is used, the times range from 0 minutes to 20 hours, typically 0.5 to 3.0 hours. Longer times are required at lower temperatures to obtain more inhibited starches.

For most applications, the thermal dehydrating and heat treating steps will be continuous and accomplished by the application of heat to the starch or flour beginning from ambient temperature. The moisture will be driven off during the heating and the starch will become anhydrous or substantially anhydrous. Usually, at these initial levels of inhibition, the peak viscosities are higher than the peak viscosities of starches heated for longer times, although there will be greater breakdown in viscosity from the peak viscosity. With continued heat treating, the peak viscosities are lower, but the viscosity breakdowns are less.

The process may be carried out as part of a continuous process involving the extraction of the starch from a plant material.

As will be seen in the following examples, the source of the starch or flour, the initial pH, the dehydrating conditions, the heating time and temperature, and the equipment used are all interrelated variables that
5 affect the amount of inhibition.

The heating steps may be performed at normal pressures, under vacuum or under pressure, and may be accomplished by conventional means known in the art. The preferred method is by the application of dry heat in dry
10 air or in an inert gaseous environment.

The heat treating step can be carried out in the same apparatus in which the thermal dehydration occurs. Most conveniently the process is continuous with the thermal dehydration and heat treating occurring in the same
15 apparatus, as when a fluidized bed is used.

The dehydrating and heat treating apparatus can be any industrial ovens, conventional ovens, microwave ovens, dextrinizers, dryers, mixers and blenders equipped with heating devices and other types of heaters, provided that
20 the apparatus is fitted with a vent to the atmosphere so that moisture does not accumulate and precipitate onto the starch or flour. The preferred apparatus is a fluidized bed. Preferably, the apparatus is equipped with a means for removing water vapor, such as, a vacuum or a blower to sweep
25 air or the fluidizing gas from the head-space of the fluidized bed. Suitable fluidizing gases are air and nitrogen. For safety reasons, it is preferable to use a gas containing less than 12% oxygen.

Superior inhibited starches having high
30 viscosities with low percentage breakdown in viscosity are obtained in shorter times in the fluidized bed than can be achieved using other conventional heating ovens or dryers.

The starches or flours may be inhibited individually or more than one may be inhibited at the same time. They may be inhibited in the presence of other materials or ingredients that would not interfere with the thermal inhibition process or alter the properties of the starch or flour product.

Sample Preparation

Unless indicated otherwise, all the starches and flours used were granular and were provided by National Starch and Chemical Company of Bridgewater, New Jersey.

The controls were from the same native source as the test samples, were unmodified or modified in the same manner as the test sample, and were at the same pH, unless otherwise indicated. All starches and flours, both test and control samples, were prepared and tested individually.

The pH of the starch samples was raised by slurring the starch or flour in water at 30-40% solids and adding a sufficient amount of a 5% sodium carbonate solution until the desired pH was reached. All samples were spray dried or flash dried, as conventional in the art (without gelatinization) to about 2-15% moisture, except for the non-thermally dehydrated starches which were generally oven dried (without gelatinization) to about 2-6% moisture.

Measurements of pH, either on samples before or after the thermal inhibition steps, were made on samples consisting of one part starch or flour to four parts water.

Except where a conventional oven or dextrinizer is specified, the test samples were dehydrated and heat treated in a fluidized bed reactor, model number FDR-100, manufactured by Procedyne Corporation of New Brunswick, New Jersey. The cross-sectional area of the fluidized bed reactor was 0.05 sq meter. The starting bed height was 0.3 to 0.8 meter, but usually 0.77 meter. The fluidizing gas

was air, except where otherwise indicated, and the air was used at a velocity of 5-15 meter/min. The sidewalls of the reactor were heated with hot oil, and the fluidizing gas was heated with an electric heater. The samples were loaded to the reactor and then the fluidizing gas was introduced, or the samples were loaded while the fluidizing gas was being introduced. No difference was noted in the samples depending on the order of loading. Unless otherwise specified, the samples were brought from ambient temperature up to no more than 125°C until the samples became anhydrous and were further heated to the specified heat treating temperature. When the heat treating temperature was 160°C, the time to reach that temperature was less than three hours.

The moisture level of the samples at the final heating temperature was 0%, except where otherwise stated. Portions of the samples were removed and tested for inhibition at the temperatures and times indicated in the tables.

Unless specified otherwise, the samples were tested for inhibition using the following Brabender Procedures.

Brabender Procedure

All samples, except for corn, tapioca and waxy rice flour, were slurried in a sufficient amount of distilled water to give a 5% anhydrous solids starch slurry. Corn, tapioca, and waxy rice flour were slurried at 6.3% anhydrous solids. The pH was adjusted to pH 3.0 with a sodium citrate/citric acid buffer. The slurry was introduced into the sample cup of a Brabender VISCO\Amylo\GRAPH fitted with a 350 cm/gram cartridge. The starch slurry was heated rapidly to 92°C and held for 10 minutes.

The peak viscosity and viscosity ten minutes (10') after peak viscosity were recorded in Brabender Units (BU). The percentage breakdown ($\pm 2\%$) in viscosity was calculated according to the formula:

$$\% \text{ Breakdown} = \frac{\text{peak} - (\text{peak} + 10')}{\text{peak}} \times 100$$

where "peak" is the peak viscosity in Brabender Units, and "(peak + 10')" is the viscosity in Brabender Units at ten minutes after peak viscosity.

If no peak viscosity was reached, that is, the data indicate a rising curve or a flat curve, the viscosity at 92°C and the viscosity at 30 minutes after attaining 92°C were recorded.

Using data from Brabender curves, inhibition was determined to be present if, when dispersed at 5-6.3% solids in water at 92°-95°C and pH 3 during the Brabender heating cycle, the Brabender data showed (i) no or almost no viscosity, indicating the starch was so inhibited it did not gelatinize or strongly resisted gelatinization; (ii) a continuous rising viscosity with no peak viscosity, indicating the starch was highly inhibited and gelatinized to a limited extent; (iii) a lower peak viscosity and a lower percentage breakdown in viscosity from peak viscosity compared to a control, indicating a moderate level of inhibition; or (iv) a slight increase in peak viscosity and a lower percentage breakdown compared to a control, indicating a low level of inhibition.

Characterization of Inhibition by Brabender Data

Characterization of a thermally inhibited starch is made more conclusively by reference to a measurement of its viscosity after it is dispersed in water and gelatinized. The instrument used to measure the viscosity is a Brabender VISCO\Amylo\GRAPH, (manufactured by C.W.

Brabender Instruments, Inc., Hackensack, NJ). The
VISCO\Amylo\GRAPH records the torque required to balance the
viscosity that develops when a starch slurry is subjected to
a programmed heating cycle. For non-inhibited starches, the
5 cycle passes through the initiation of viscosity, usually at
about 60°-70°C, the development of a peak viscosity in the
range of 65°-95°C, and any breakdown in viscosity when the
starch is held at the elevated temperature, usually 92°-
95°C. The record consists of a curve tracing the viscosity
10 through the heating cycle in arbitrary units of measurement
termed Brabender Units (BU).

Inhibited starches will show a Brabender curve
different from the curve of the same starch that has not
been inhibited (hereinafter the control starch). At low
15 levels of inhibition, an inhibited starch will attain a peak
viscosity somewhat higher than the peak viscosity of the
control, and there may be no decrease in percentage
breakdown in viscosity compared to the control. As the
amount of inhibition increases, the peak viscosity and the
20 breakdown in viscosity decrease. At high levels of
inhibition, the rate of gelatinization and swelling of the
granules decreases, the peak viscosity disappears, and with
prolonged cooking the Brabender trace becomes a rising curve
indicating a slow continuing increase in viscosity. At very
25 high levels of inhibition, starch granules no longer
gelatinize, and the Brabender curve remains flat.

Characterization of Inhibition by Texture

Starches or flours with a low to moderate degree
of inhibition will exhibit certain textural characteristics
30 when dispersed in an aqueous medium and heated to
gelatinization. In the following examples, the starches or
flours were determined to be inhibited if a heated

gelatinized slurry of the starch or flour exhibited a non-cohesive, smooth texture.

Brabender Procedure - Crosslinked Starches

The crosslinked, thermally-inhibited cationic and amphoteric starches (23.0 g) to be tested were combined with 30 ml of an aqueous solution of citric acid monohydrate (prepared by diluting 210.2 g of citric acid monohydrate to 1000 ml in a volumetric flask) and sufficient water was added to make the total charge weight 460.0 g. The slurry is added to the cooking chamber of the Brabender VISCO amylo GRAPH fitted with a 700 cm/gram cartridge and rapidly heated from room temperature to 95°C. The peak viscosity (highest viscosity observed) and the viscosity after 30 minutes at 95°C were recorded. The percentage breakdown in viscosity ($\pm 2\%$) was calculated according to the formula

$$\% \text{ Breakdown} = \frac{\text{Peak} - (\text{Viscosity after 30' at 95°C})}{\text{Peak}} \times 100$$

Brookfield Viscometer Procedure

Test samples are measured using a Model RVT Brookfield Viscometer and the appropriate spindle (the spindle is selected based on the anticipated viscosity of the material). The test sample, usually a cooked starch paste, is placed in position and the spindle is lowered into the sample to the appropriate height. The viscometer is turned on and the spindle is rotated at a constant speed (e.g., 10 or 20 RPM) for at least 3 revolutions before a reading is taken. Using the appropriate conversion factors, the viscosity (in centipoises) of the sample is recorded.

Angle Of Repose Determination

This test measure the flow properties of the starch or flour. A large sheet of heavy Kraft paper (about 6 ft. square) is secured to a flat, level surface with masking tape. Two rings (3 in. and 4 in. in diameter) are

clamped onto a ring stand (6 x 9 in. base and 24 in. rod) in such a way that the base faces in the opposite direction from the rings. The small ring is placed above the larger ring. To keep the funnels stationary, 1 in. pieces of heavy
5 walled vacuum tubing (1/4 in. base by 3/16 in. wall) are cut lengthwise through one wall and fitted equidistantly at 3 locations on each ring. A chemical funnel having a 100 mm top interior diameter (ID) (Kimax 58) is modified by removing the existing stem and annealing a 8 mm I.D. glass
10 tubing 85 mm in length as the stem. The modified funnel is placed in the large ring and the height is adjusted so that the orifice of the funnel is 1 ± 0.1 cm above the paper. A powder funnel having a 60 mm top I.D. and 13 mm stem I.D. (Kimax 29020-04) is placed in the small ring and the ring is
15 lowered as far as possible, i.e., until the clamps meet. The small funnel should be centered above the large funnel with the orifice of the large funnel stem parallel to the paper. Approximately 50 g of the sample to be tested are slowly added to the powder funnel while gently placing the
20 top of an index finger over the orifice of the large funnel so that any sample which overflows the powder funnel does not flow out of the large funnel. The finger is slowly removed from the orifice while taking care not to move the funnel and allow the sample to flow onto the paper. Flow
25 will cease when the top of the pile reaches the orifice of the funnel stem. With a pencil, the circumference of the sample pile is traced as accurately as possible without disturbing the sample. The sample is removed and the radius of the pile is measured. Each sample is run in triplicate.
30 The test is repeated if the funnel stem becomes clogged before the pile meets the funnel orifice or if the pile is disturbed in any way. The funnels are cleaned after each run.

The average radius of the sample pile is calculated and the angle of repose is determined using the following formula:

$$\text{Tangent (angle of repose)} = \frac{\text{height of funnel orifice}}{\text{average radius of pile}}$$

5

Horiba Wet Particle Size Determination

For determination of the Horiba wet particle size determination, the thermally-inhibited starches were analyzed, according to the instruction manual-version 1.81C, of the Horiba, Model #LA-900, Laser Scattering Particle Size Distribution Analyzer (Horiba Instrument Inc., Irvine, CA 92174). This determination requires that the sample be added under agitation to a cup which contains distilled or de-ionized water until a desired concentration is achieved. The software package then automatically initiates the analysis.

15

Characterization of Inhibition by Cooks

A dry blend of 7 g of starch or flour (anhydrous basis) and 14 g of sugar were added to 91 ml of water in a Waring blender cup at low speed, then transferred to a cook-up beaker, allowed to stand for 10 minutes, and then evaluated for viscosity, color, clarity and texture.

20

Some of the granular non-pregelatinized starch samples were tested for pasting temperature and/or gelatinization temperature using the following procedures.

25

Rapid Visco Analyzer (RVA)

This test is used to determine the onset of gelatinization, i.e., the pasting temperature. The onset of gelatinization is indicated by an increase in the viscosity of the starch slurry as the starch granules begin to swell.

30

A 5 g starch sample (anhydrous basis) is placed in the analysis cup of a Model RVA-4 Analyzer and slurried in water at 20% solids. The total charge is 25 g. The cup is

placed into the analyzer, rotated at 160 rpm, and heated from an initial temperature of 50°C up to a final temperature of 80°C at a rate of 3°C/minute. A plot is generated showing time, temperature, and viscosity in centipoises (cP). The pasting temperature is the temperature at which the viscosity reaches 500 cP. Both pasting temperature and pasting time are recorded.

Differential Scanning Calorimetry (DSC)

This test provides a quantitative measurement of the enthalpy (ΔH) of the energy transformation that occurs during the gelatinization of the starch granule. The peak temperature and time required for gelatinization are recorded. A Perkin-Elmer DSC-4 differential scanning calorimeter with data station and large volume high pressure sample cells is used. The cells are prepared by weighing accurately 10 mg of starch (dry basis) and the appropriate amount of distilled water to approximately equal 40 mg of total water weight (moisture of starch and distilled water). The cells are then sealed and allowed to equilibrate overnight at 4°C before being scanned at from 25-150°C at the rate of 10°C/minute. An empty cell is used as the blank.

Brookfield Viscometer Procedure

Test samples are measured using a Model RVT Brookfield Viscometer and the appropriate spindle (the spindle is selected based on the anticipated viscosity of the material). The test sample, usually a cooked starch paste, is placed in position and the spindle is lowered into the sample to the appropriate height. The viscometer is turned on and the spindle is rotated at a constant speed (e.g., 10 or 20 rpm) for at least 3 revolutions before a reading is taken. Using the appropriate conversion factors, the viscosity (in centipoises) of the sample is recorded.

EXAMPLES

The following examples will more fully illustrate the embodiments of the invention. In the examples, all parts are given by weight and temperature are in degrees Celsius unless otherwise noted. The thermally-inhibited starches and controls in the following examples were prepared as described above and are defined by textural characteristics or in relation to data taken from Brabender curves using the above described procedures. The thermally-inhibited starches and flours are referred to as "T-I" starches and flours and the conditions used for their preparation (i.e., pH to which the starch is adjusted and heat treatment temperature and time at that temperature are included in parenthesis - (pH; temperature/hold time at that temperature). All pH adjustments are done with sodium carbonate unless specified otherwise. Unless otherwise specified, the thermally-inhibited starches and flours referred to as "granular" starches are non-pregelatinized granular starches and flours.

In the first three examples, the moisture indicated is the moisture of the starch before the dehydration and heat treating steps. As indicated above, as the starches were brought from ambient temperature up to the heating temperature, the starches became anhydrous or substantially anhydrous.

In the tables the abbreviations "sl.", "mod.", "v.", "ris." and "N.D." stand for slight or slightly, moderate or moderately, very, rising, and not determined.

EXAMPLE 1

This example illustrates the preparation of the starches of this invention from a commercial granular waxy maize base starch by the heat treatment process of this invention.

Processing conditions and their effects on viscosity and texture of waxy maize starch are set forth in the Tables below.

To obtain a heat-stable, non-cohesive thickener, samples of granular starch were slurried in 1.5 parts of water, the pH of the slurry was adjusted with the addition of a 5% Na_2CO_3 solution and the slurry was agitated for 1 hour, then filtered, dried, and ground. The dry starch samples (150 g) were placed into an aluminum foil pan (4" x 5" x 1-1/2") and heated in a conventional oven under the conditions described in Tables I and II. Brabender viscosity measurements demonstrated that the most heat-stable starches were obtained by heating at 160°C and a pH of at least 8.0 for about 3.5 to 6.0 hours.

	Waxy Maize ^a	<u>Process Variables</u>			<u>Cold Evaluation of Gelatinized Samples^{d,e}</u>	
		<u>Heating - 160°C</u>				
		<u>pH</u>	<u>Mois- ture (%)</u>	<u>Time (hrs.)</u>	<u>Viscosity</u>	<u>Texture</u>
15	1	6.0	10.9	2	heavy to v. heavy	cohesive
20	2	6.0	10.9	4	thin to mod.	--
	3	8.2	10.6	3.5	heavy to v. heavy	cohesive, less than unmodified control
	4	8.2	10.6	4	heavy to v. heavy	sl. to mod. cohesive
	5	8.2	10.6	4.5	heavy	non- cohesive
25	6	8.2	10.6	5.5	heavy, thinnest	non- cohesive
	7	8.2	10.6	6	mod. heavy	non- cohesive

unmod- ified ^b	--	--	v. heavy	cohesive
cross- linked ^c	--	--	v. heavy	non- cohesive

5

- a. All samples were commercial samples of granular waxy maize starch obtained from National Starch and Chemical Company, Bridgewater, New Jersey.
- b. The unmodified control was a commercial granular waxy maize starch obtained from National Starch and Chemical Company, Bridgewater, New Jersey.
- c. The modified control was a commercial crosslinked (phosphorous oxychloride treated) granular waxy maize starch obtained from National Starch and Chemical Company, Bridgewater, New Jersey.
- d. Samples were cooked by slurring 7.0 g of starch (at 12% moisture) in 91 mls water at neutral pHs and heating the starch slurry for 20 minutes in a boiling water bath.
- e. The cold evaluation was carried out at 25°C.

Brabender Evaluation

	Waxy Maize ^a	<u>Process Variables</u>			<u>Brabender Viscosity^b</u> (BU)	
		<u>pH</u>	<u>Heating Temp. (°C)</u>	<u>Time (hrs.)</u>	<u>Peak Viscosity</u>	<u>Viscosity at 95°C/ 20 mins.</u>
30						
	3	8.2	160	3.5	985	830
	4	8.2	160	4.0	805	685
	5	8.2	160	4.5	640	635
	6	8.2	160	5.5	575	570
35	Unmodified control	--	none	none	1640	630
	1	6.0	160	2.0	1055	560
	2	6.0	160	4.0	140	80

- a. See Table I for a description of samples.
- b. In the Brabender procedure, a sample containing 5.4% anhydrous solids of starch dispersed in water was heated rapidly to 50°C, then the heat was increased by 1.5°C per minute to 95°C, and held for 20 minutes.

EXAMPLE 2

This example illustrates that a variety of granular starches may be processed by the method of this invention to provide a non-cohesive thickener with properties similar to chemically crosslinked starches.

Processing conditions and their effects on the viscosity and texture of waxy barley, tapioca, V.O. hybrid and waxy rice starches are set forth in the tables below.

Process Variables

	<u>Sample^a</u>	<u>Heating - 160°C</u>			<u>Cold Evaluation of Gelatinized Sample^b</u>	
	<u>pH</u>	<u>Mois- ture (%)</u>	<u>Time (hrs.)</u>	<u>Viscosity/Texture</u>		
20	<u>Waxy Barley Starch</u>					
	1	8.7	8.5	1.5	heavy	cohesive
	2	8.7	8.5	2.5	heavy	sl. mod. cohesive
	3	8.7	8.5	3.5	mod. heavy to heavy	non- cohesive
25	4	5.2	10.8	1.5	thin	--
	5	5.2	10.8	2.5	thin/ thinnest	--
	Waxy Barley Control	--	--	0	heavy	cohesive
30	<u>Tapioca Starch</u>					
	6	8.8	10.3	2	heavy to v. heavy	cohesive

	7	8.8	10.3	3	heavy to v. heavy	cohesive/ less than Sample 6
	8	8.8	10.3	4	heavy to v. heavy	sl. cohesive to sl. lumpy
	9	8.8	10.3	5	heavy	non- cohesive lumpy
	10	5.5	10.9	3	mod. heavy	--
5	Tapioca Control	--	--	0	v. heavy	cohesive
	<u>Waxy Rice Starch</u>					
	1	9.1	9.0	2	v. heavy	cohesive
	2	9.1	9.0	3	heavy	sl. cohesive
10	3	9.1	9.0	4	heavy	sl. cohesive
	4	9.1	9.0	5	mod. heavy to heavy	non- cohesive
	Waxy Rice Control	--	--	0	v. heavy	cohesive
15	a. Tapioca starch samples were commercial granular starch obtained from National Starch and Chemical Company, Bridgewater, New Jersey. Waxy barley starch samples were commercial granular starch obtained from AlKo, Finland. Waxy rice starch samples were commercial granular starch obtained from Mitsubishi Corporation, Japan.					
20						
25	b. Samples were cooked by slurring 7.5 g of starch at 12% moisture in 100 mls of water and heating the starch slurry for 20 minutes in a boiling water bath.					

Process Variables

30	<u>Sample^a</u>	<u>Heating - 160°C</u>	<u>Cold Evaluation of Gelatinized Sample^b</u>
----	---------------------------	------------------------	--

		<u>pH</u>	<u>Mois- ture</u> (%)	<u>Time</u> (hrs.)	<u>Viscosity/Texture</u>	
	<u>V.O. Hybrid Starch</u>					
	1	8.7	10.5	2.0	heavy	cohesive v. sl. less than control
	2	8.7	10.5	3.0	heavy	sl. mod. cohesive
5	3	8.7	10.5	4.0	mod. heavy to heavy	smooth, very sl. cohesive
	4	8.7	10.5	5.0	mod. heavy	smooth, short, non- cohesive
	5	8.7	10.5	6.0	moderate	smooth, short, non- cohesive
10	V.O. Hybrid Control	5.9	11.4	0	heavy	cohesive
15	a. V.O. hybrid starch samples were granular starches obtained from National Starch and Chemical Company, Bridgewater, New Jersey.					
	b. Samples were cooked by slurrying 7.5 g of starch at 12% moisture in 100 mls of water and heating the starch slurry for 20 minutes in a boiling water bath.					
20	The viscosity and texture evaluation results show that a non-cohesive, heat-stable starch thickener may be prepared from waxy barley, V.O. hybrid, tapioca and waxy rice starches by the process of this invention. The amount of inhibition (non-cohesive, thickening character in cooked aqueous dispersion) increased with increasing time of heat treatment.					
25						

EXAMPLE 3

This example illustrates the effects of temperature, the pH, and starch moisture content on the viscosity and texture of the treated starch.

5 Part A

A waxy maize starch sample (100 g) containing 20.4% moisture was heated in an oven at 100°C for 16 hours in a sealed glass jar. A second sample was heated for 4 hours and a third sample was heated for 7 hours under the same conditions. The product viscosity and texture were compared to a 12.1% moisture granular waxy maize starch control using the cook evaluation method of Example 1, Table I. Results are shown in Table V, below.

<u>Effect of Process Moisture</u>				
15	<u>Waxy Maize^a</u>	<u>Process Variables^b</u>	<u>Cold Evaluation of Gelatinized Starch^c</u>	
		<u>Heat Time (hrs.)</u>	<u>Viscosity</u>	<u>Texture</u>
	1. Test (20.4% H ₂ O)	16	heavy, sl. thinner than control	cohesive
20	2. Control (12.1% H ₂ O)	0	heavy	cohesive
	3. Test (20.4% H ₂ O)	4	heavy	cohesive
	4. Control (12.1% H ₂ O)	0	heavy	cohesive
25	5. Test (20.4% H ₂ O)	7	heavy	cohesive
	6. Control (12.1% H ₂ O)	0	heavy	cohesive
30	a. Samples were obtained from National Starch and Chemical Company, Bridgewater, New Jersey.			
	b. Process was conducted at pH 5.2.			
35	c. See Table III for cook conditions.			

The results demonstrate that moisture added during the process yields a product which is as cohesive and undesirable as a control starch which had not been heated.

Part B

5 Samples (900 g) of a commercial granular waxy maize starch (obtained from National Starch and Chemical Company, Bridgewater, New Jersey) were placed in a 10" x 15" x 0.75" aluminum tray and heated in an oven at 180°C for 15, 30, 45 and 60 minutes. The pH of the starch was not
10 adjusted and remained at about 5.2 during the heating process. Sample viscosity and texture were evaluated by the method of Example 1.

 As shown in the following table, the pH 5.2 samples were characterized by an undesirable, cohesive
15 texture similar to that of a waxy maize starch control which had not been heat treated.

Effect of Acidic Process pH

	<u>Sample</u>	<u>Process Variables^a</u>	<u>Cold Evaluation of Gelatinized Starch^b</u>	
		<u>Heating Time (minutes)</u>	<u>Viscosity</u>	<u>Texture</u>
20	1	15	v. heavy	cohesive
	2	30	v. heavy	cohesive
	3	45	v. heavy	cohesive
25	4	60	heavy to v. heavy	cohesive
	Control	0	v. heavy	cohesive

a. The pH was not adjusted from that of the native waxy maize starch (a pH = 5.2) and Samples 1-4 correspond to starch treated by the process of
30 U.S. Pat. No. 4,303,451 (no pH adjustment).

b. See Table III for cook conditions.

Thus, a combination of selected factors, including the pH, moisture content and the type of native starch, determine whether a desirable, non-cohesive, heat-stable starch thickener is produced by the process of this invention.

EXAMPLE 4

This example shows carrying out the thermal inhibition in the fluidized bed previously described. The effects of temperature and time at the indicated temperature on the level of inhibition of waxy maize granular starch at pH 9.5 are shown below.

		<u>Viscosity (B.U.)</u>		
<u>Heating Temperature and Time</u>		<u>Peak</u>	<u>Peak + 10'</u>	<u>Break-down (%)</u>
	Control (none)	1135	730	64.3
15	110°C for 22 hrs.	1185	970	18.1
	160°C for 0 hr.	1055	880	16.6
	160°C for 2 hrs.	665	660	0.7
	175°C for 0 hr.	850	755	11.2
	180°C for 0 hr.	715	680	4.9
20	190°C for 0 hr.	555	550	0.9
	200°C for 0 hr.	ris.	--	--
	200°C for 2 hrs.	none	--	--

The data shows that inhibited anhydrous or substantially anhydrous samples can be obtained at heat treating temperatures between 100-200°C, with more inhibition obtained at higher temperatures or at longer times at lower temperatures. The starch samples heated at 200°C were highly inhibited (rising curves) or completely inhibited (no gelatinization).

EXAMPLE 5

Samples of tapioca starch, waxy maize starch, and waxy rice flour at pH 9.4 to 9.6 were dehydrated to less than 1% moisture at a temperature below 125°C, equilibrated to 160°C in a thermal reactor (a horizontal double ribbon jacketed vessel). The heat treating time for the samples ranged from three to six hours.

The samples were evaluated for inhibition according to the previously described Brabender procedure and the results are given in the following table.

Starch at (pH 9.4-9.6)		Viscosity (BU)		
		Peak	Peak + 10'	Breakdown (%)
Tapioca	Control	1300	385	70.4
	T-I	340	295	13.2
Waxy Maize	Control	1135	405	64.3
	T-I	580	560	3.5
Waxy Rice Flour	Control	1140	307	73.1
	T-I	600	590	1.7

The dehydrated and heated starches and flour inhibited a viscosity inhibited from breakdown relative to the controls that were not dehydrated and heated. This inhibition correlated to a short, noncohesive texture in the cooled product.

EXAMPLE 6

The effects of initial pH and heat treating time on the level of inhibition on samples of waxy maize starch at naturally occurring pH (about 6.0) and at pH 7.5, pH 8.5 and pH 9.5 were evaluated and the data set out in the following table.

Waxy Maize Heat Treated at 160°C
Effects of Initial pH and Heating Time

5	Initial pH	Heating Time (min)	Viscosity (BU)		Breakdown (%)
			Peak Viscosity (BU)	Peak at 10' (BU)	
10	6.0	control	1135	405	64.3
		0	1058	463	56.4
		30	710	460	35.2
		60	645	445	31
15	6.0	90	570	440	22.8
		120	560	440	21.4
		150	485	395	18.6
	7.3	90	645	500	22.5
		120	580	450	22.4
		150	572	445	22.2
		180	522	427	18.1
20	8.5	0	980	630	35.7
		30	770	655	14.9
		60	665	615	6.0
		90	625	600	4.0
25	9.5	120	585	580	0.9
		0	1055	880	16.6
		30	825	800	3.0
		60	705	700	0.7
30		90	690	690	0
		120	665	660	0.7

The data show that starches with varying levels of inhibition, as reflected by the variance in percentage breakdown in viscosity, can be obtained at different heating times and initial pHs, and that a higher degree of inhibition can be obtained at the higher pH values and at longer heating times. Moreover, comparing the shortened heat treating times in this Example, in which the fluidized bed reactor was used, with the heat treating times in hours

in Examples 4 and 5, it can be seen that inhibited starches with higher peak viscosities can be obtained at much shorter times using the fluidized bed than are possible with standard thermal reactors or ovens.

5

EXAMPLE 7

The effects of temperature and time on the level of inhibition of waxy maize starch at pH 9.5 were evaluated. The results are set forth in the following table.

Effects of Heating Temperature and Time

10

	Heating Temp.	Time At Heating Temp. (hrs)	<u>Viscosity</u> (BU)		<u>Break-down</u> (%)
			<u>Peak</u>	<u>Peak + 10'</u>	
	Control	--	1135	730	64.3
15	110°C	22	1185	970	18.1
	160°C	0	1055	880	16.6
	160°C	2	665	660	0.7
	175°C	0	850	755	11.2
	180°C	0	715	680	4.9
20	190°C	0	555	550	0.9
	200°C	0	ris.	--	--
	200°C	2	none	--	--

The data show that inhibited starches can be obtained at heat treating temperatures between 100°-200°C, with more inhibition obtained at higher temperatures or at longer times with lower temperatures. The starch samples heated at 200°C were highly inhibited (rising curves) or completely inhibited (no gelatinization).

25

EXAMPLE 8

Waxy maize starch at initial pH of 9.5 was evaluated for inhibition in the presence of between 1-2% moisture by weight of the sample by injecting saturated air into the chambers of the fluidized bed reactor.

5 The results are set out in the following tables.

	<u>Waxy Maize</u> (pH 9.5; 0% Moisture)		<u>Viscosity</u> (BU)				<u>Breakdown</u> (%)
			<u>Peak</u>	<u>Peak + 10'</u>	<u>92°C</u>	<u>92°C + 30'</u>	
	Control		1140	410			64
10	<u>Temp</u> (°C)	<u>Time</u> (min)					
	140	0	1260	500	---	---	60
	150	0	1160	540	---	---	45
	155	0	1100	720	---	---	35
15	160	0	1080	840	---	---	22
	160	0	930	825	---	---	11
	160	15	760	740	---	---	3
	160	30	700	690	---	---	1
	160	45	695	690	---	---	1
20	160	60	---	---	490	690	ris.
	160	90	605	590	414	590	ris.
	160	120	---	---	320	580	ris.
	160	150	---	---	200	480	ris.

25

* Rising viscosity.

	<u>Waxy Maize</u> (pH 9.5; 1-2% Moisture)		<u>Viscosity</u> (BU)				<u>Breakdown</u> (%)
			<u>Peak</u>	<u>Peak + 10'</u>	<u>92°C</u>	<u>92°C + 30'</u>	
30	Control		1140	410			64

	<u>Temp</u> (°C)	<u>Time</u> (min)					
	155	0	1215	465	--	--	62
	160	0	1090	530	--	--	51
5	160	15	985	740	--	--	25
	160	30	885	700	--	--	21
	160	45	750	530	--	--	29
	160	60	700	480	--	--	31
	160	90	685	505	--	--	26
10	160	120	610	450	--	--	26
	160	150	580	430	--	--	26
	160	180	530	400	--	--	25

The results show that more inhibition can be obtained when the starch is heat treated at anhydrous or substantially anhydrous condition than if heat treated in the presence of moisture (note the lower percentage in viscosity breakdown for the anhydrous samples).

EXAMPLE 9

Waxy maize samples at an initial moisture content of 10.9% were introduced to a fluidized bed reactor with a nitrogen fluidizing gas containing ammonia in the concentrations specified in the tables. The samples were evaluated for the effect of the ammonia gas on the level of inhibition.

	<u>Waxy Maize</u> (0.1% NH ₃ in N ₂)	<u>Viscosity</u> (BU)		<u>Breakdown</u> (%)	<u>Final</u> <u>pH</u>	
		<u>Peak</u>	<u>Peak + 10'</u>			
	Control	1040	200	81	--	
30	<u>Temp</u> (°C)	<u>Time</u> (min)				
	160	0	965	450	53	8.7

160	60	625	420	33	8.6
160	120	440	325	26	8.9
160	180	340	290	15	8.8
160	240	300	250	17	8.4

5

Comparing the results to those obtained in Example 6 at pH 9.5, it can be seen that ammonia gas is effective to raise the pH of the starch and prevent hydrolysis, but is not as effective as direct pH adjustment of the starch in preventing hydrolysis and promoting inhibition.

10

	<u>Waxy Maize</u>		<u>Viscosity</u>		<u>Breakdown</u>	<u>Final</u>
	<u>(1% NH₃ in N₂)</u>		<u>(BU)</u>		<u>(%)</u>	<u>pH</u>
			<u>Peak</u>	<u>Peak + 10'</u>		
	Control		1040	200	81	
15	<u>Temp</u>	<u>Time</u>				
	<u>(°C)</u>	<u>(min)</u>				
	160	0	1100	460	58	8.9
	160	60	670	470	30	8.8
	160	120	505	405	20	8.9
20	160	180	410	345	16	8.9
	160	210	380	320	16	9.8

	<u>Waxy Maize</u>		<u>Viscosity</u>		<u>Breakdown</u>	<u>Final</u>
	<u>(10% NH₃ in N₂)</u>		<u>(BU)</u>		<u>(%)</u>	<u>pH</u>
			<u>Peak</u>	<u>Peak + 10'</u>		
	Control		1040	200	81	
	<u>Temp</u>	<u>Time</u>				
	<u>(°C)</u>	<u>(min)</u>				
	160	0	1020	390	62	9.7
30	160	60	730	410	44	9.6
	160	120	540	360	33	9.6
	160	180	415	310	25	10.2

160 240 330 270 18 10.4

EXAMPLE 10

Waxy maize samples were introduced to a fluidized bed reactor and sprayed with a 25% solution of sodium carbonate, while the fluidizing gas was being introduced, in order to raise the pH. The samples were then brought from ambient temperature to 160°C in less than three hours, and held at 160°C for the times specified in the table.

The samples were evaluated for inhibition. The data show that this technique is successful for raising the pH of the samples in order to prevent acid hydrolysis and promote inhibition.

	<u>Waxy Maize</u> (with Na ₂ CO ₃)		<u>Viscosity</u> (BU)		<u>Breakdown</u> (%)	<u>Final</u> <u>pH</u>
			<u>Peak</u>	<u>Peak + 10'</u>		
	Control		1040	200	81	--
	<u>Temp</u> (°C)	<u>Time</u> (min)				
20	160	0	1000	500	50	9.4
	160	30	750	530	29	9.2
	160	60	645	500	22	9.1
	160	180	465	400	14	9

EXAMPLE 11

The effect of the fluidizing gas on the level of inhibition was evaluated on waxy maize samples at pH 9.5 fluidized with nitrogen gas and with air. The samples were tested for inhibition and the data show that a higher rate of inhibition is attained when air is used as a fluidizing gas compared to nitrogen.

	<u>Waxy Maize</u>		<u>Nitrogen</u>			<u>Air</u>		
	(pH 9.5)		<u>Viscosity</u>			<u>Viscosity</u>		
			(BU)			(BU)		
	<u>Temp.</u>	<u>Time</u>	<u>Peak</u>	<u>Peak</u>	<u>Breakdown</u>	<u>Peak</u>	<u>Peak</u>	<u>Breakdown</u>
		(min)		+ 10'	(%)		+ 10'	(%)
5	160	0	1055	880	16.6	1055	880	16.6
	160	30	1150	920	20.0	825	800	3.0
	160	60	985	870	11.7	705	700	0.7
	160	90	875	810	7.4	690	690	0
10	160	120	865	815	5.9	665	660	0.7
	160	180	820	755	7.9	630	620	1.6

EXAMPLE 12

The effects of initial pH and heat treating times at 160°C on the level of inhibition on samples of corn starch at its naturally occurring pH, and at an initial pH 9.5, were evaluated.

The results set out in the following tables.

	<u>Corn</u>		<u>Viscosity</u>				<u>Breakdown</u>
	(natural pH)		(BU)				(%)
			<u>Peak</u>	<u>Peak</u>	<u>92°C</u>	<u>92°C</u>	
	<u>Temp</u>	<u>Time</u>		+ 10'		+ 30'	
	(160°C)	(min)					
20	Control		640	420			34
		0	560	370	--	--	34
		30	510	330	--	--	35
25		60	500	400	--	--	20
		90	450	360	--	--	20
		120	410	335	--	--	18

30

<u>Corn</u> (pH 9.5)		<u>Viscosity</u> (BU)				<u>Breakdown</u> (%)
		<u>Peak</u>	<u>Peak + 10'</u>	<u>92°C</u>	<u>92°C + 30'</u>	<u>Breakdown</u> (%)
Control		660	550			17
5	<u>Temp</u> (160°C)	<u>Time</u> (min)				
	0	990	900	--	--	9
	30	940	910	--	--	3
	60	--	--	20	910	ris.
	90	--	--	20	690	ris.
10	120	--	--	20	510	ris.

The data show that very high levels of inhibition can be obtained at basic pH (note increasing viscosity) compared to natural pH, and that more inhibition is obtained with longer heat-treating times.

EXAMPLE 13

The effect of initial pH on the level of inhibition on samples of potato starch at naturally occurring pH and at initial pH 9.5 was evaluated.

The results set out in the following tables.

<u>Potato</u> (natural pH)		<u>Viscosity</u> (BU)				<u>Breakdown</u> (%)
		<u>Peak</u>	<u>Peak + 10'</u>	<u>92°C</u>	<u>92°C + 30'</u>	
Control		785	310			61
25	<u>Temp</u> (°C)	<u>Time</u> (min)				
	125	0	560	360	--	36
	160	0	240	140	--	42
	160	90	22	15	--	32
	160	180	20	18	--	10

<u>Potato</u> (pH 9.5)		<u>Viscosity</u> (BU)				<u>Breakdown</u> (%)	
		<u>Peak</u>	<u>Peak</u> <u>+ 10'</u>	<u>92°C</u>	<u>92°C</u> <u>+ 30'</u>		
	Control	690	390			43	
5	<u>Temp</u> (160°C)	<u>Time</u> (min)					
		0	640	480	--	--	25
		30	940	795	--	--	15
		60	1020	900	--	--	12
		90	995	945	--	--	5
10		120	--	--	800	980	ris.
		150	--	--	650	870	ris.
		180	--	--	350	680	ris.

The Brabender data at naturally occurring pH indicate that starch degradation, rather than inhibition, occurred as heat treating progressed. This example illustrates that thermal inhibition can be a function of both pH and the starting starch. In this case, thermal inhibition of potato starch appears to be more dependent on pH compared to other starches (for example, waxy maize). Therefore, the conditions required for dehydration and successful thermal inhibition of potato starch are more strict in order to avoid hydrolysis and degradation.

Dehydration and heat treating in the basic pH range, however, provided inhibited starches that maintained high viscosities, and at heat treating times over 90 minutes, provided highly inhibited starches as indicated by a continuous increasing viscosity.

EXAMPLE 14

Samples of a high amylose containing starch (Hylon V) at natural pH and pH 9.5 were evaluated for the effect of high amylose content on inhibition.

Due to the high levels of amylose, it was necessary to use a pressurized Visco/amylo/Graph (C.W. Brabender, Hackensack, NJ) to obtain Brabender curves. Samples were slurried at 10% starch solids, heated to 120°C and held for 30 minutes.

5

	<u>High Amylose Corn</u>	<u>natural pH</u>			<u>pH 9.5</u>		
		<u>Viscosity</u> (BU)	<u>peak</u> <u>+ 10'</u>	<u>Break-</u> <u>down</u> (%)	<u>Viscosity</u> (BU)	<u>peak</u> <u>+ 10'</u>	<u>Break-</u> <u>down</u> (%)
		<u>peak</u>			<u>peak</u>		
10	Control	1180	525	55.5	1180	525	55.5
	160°C Time (min)						
	0	700	235	66			
15	120	282	25	91	290	225	22

The data show that inhibition was obtained only on the high pH sample.

EXAMPLE 15

20 This example shows that a granular starch can be dehydrated by ethanol extraction and that a better tasting starch is obtained.

25 A granular waxy maize starch was slurried in 1.5 parts water based on the weight of the starch and adjusted to pH 7 and 9.5 with 5% sodium carbonate, held for 30 minutes, filtered, and dried on a tray to a moisture content of about 5-6% moisture. The starch having the pH of 5.3 was a native starch which was not pH adjusted.

30 For the dehydration, the dried pH 5.3, pH 7.0, and pH 9.5 starches were each separated into two samples. One sample was dried on trays in a forced draft oven at 80°C overnight to thermally dehydrate the starch to <1% (0%)

moisture. The other sample was placed in a Soxhlet extractor and allowed to reflux overnight (about 17 hours) with anhydrous ethanol (boiling point 78.32°C). The ethanol-extracted sample was placed on paper so that the excess alcohol could flash off which took about 30 minutes. The ethanol-extracted starch was a free flowing powder which was dry to the touch.

For the heat treatment, the oven-dehydrated starches and ethanol-extracted starches were placed on trays in a forced draft oven and heated for 3, 5, and 7 hours at 160°C.

The thermally-inhibited (T-I) starches and the controls were evaluated using the Brabender Procedure previously described was used. The results are shown below:

BRABENDER RESULTS

			<u>Viscosity (BU)</u>			
		<u>Dehydration Method</u>	<u>Heat Treat- ment</u> (160°C)	<u>Peak</u>	<u>Peak + 10'</u>	<u>Break- down</u> (%)
<u>Waxy Maize (pH 5.3)</u>						
20	Control	--	--	1245	330	74
	Dehydrated	oven	--	1290	350	73
	Dehydrated	ethanol	--	1205	245	80
	T-I	oven	5 hrs.	95	45	53
	T-I	ethanol	5 hrs.	255	185	28
25	T-I	oven	7 hrs.	60	35	42
	T-I	ethanol	7 hrs.	165	105	36
	<u>Waxy Maize (pH 7.0)</u>					
	Dehydrated	oven	--	1240	380	69
	T-I	oven	7 hrs.	298	240	20
	T-I	ethanol	7 hrs.	400	310	23
30	<u>Waxy Maize (pH 9.5)</u>					

	Dehydrated	oven	--	1250	400	68
	Dehydrated	ethanol	--	1070	350	67
	T-I	ethanol	3 hrs.	665	635	5
	T-I	oven	3 hrs.	680	655	4
5	T-I	oven	5 hrs.	245	460	ris.
	T-I	ethanol	5 hrs.	160	375	ris.
	T-I	Oven	7 hrs.	110	295	ris.
	T-I	Ethanol	7 hrs.	110	299	ris.

10 The results show that the starches can be
 dehydrated by ethanol extraction. The results also show
 that dehydration without the subsequent heat treatment did
 not inhibit the starch. The viscosity breakdown was not
 significantly different from that of the native waxy maize
 15 starch. Both of the thermally-inhibited pH 7 starches were
 higher in viscosity than the pH 5.3 (as is) thermally-
 inhibited starches. The starches which were thermally-
 inhibited at pH 9.5 were moderately highly inhibited or
 highly inhibited (rising curve).

20 EXAMPLE 16

Granular tapioca, corn, and waxy rice starches and
 waxy rice flour were adjusted to pH 9.5, dehydrated in an
 oven and by extraction with ethanol, and heat treated at
 160°C for the indicated time. They were evaluated for
 25 Brabender viscosity using the procedure previously
 described.

The Brabender results are shown below.

		<u>Viscosity (BU)</u>			
30		Heat Treat- ment Time	Peak	Peak +10'	Break- down (%)
	<u>Starch</u>	<u>Dehydration Method</u>	<u>Peak</u>		
	Tapioca (pH 9.5 and 160°C)				

	Dehydrated oven	--	745	330	58
	Dehydrated ethanol	--	720	330	54
	T-I oven	5 hrs.	270	260	3
	T-I ethanol	5 hrs.	260	258	1
5	T-I oven	7 hrs.	110	155	ris.
	T-I ethanol	7 hrs.	100	145	ris.
	<u>Corn (pH 9.5 and 160°C)</u>				
	Dehydrated oven	--	330	280	15
	Dehydrated ethanol	--	290	250	14
10	T-I oven	5 hrs.	10	80	ris.
	T-I ethanol	5 hrs.	10	170	ris.
	T-I oven	7 hrs.	10	65	ris.
	T-I ethanol	7 hrs.	10	45	ris.
	<u>Waxy Rice (pH 9.5 and 160°C)</u>				
15	Dehydrated oven	--	1200	590	50.8
	Dehydrated ethanol	--	1155	450	61.0
	T-I oven	5 hrs.	518	640	ris.
	T-I oven	7 hrs.	265	458	ris.
	T-I ethanol	7 hrs.	395	520	ris.
20	<u>Waxy Rice Flour (pH 9.5 and 160°C)</u>				
	Dehydrated oven	--	895	700	22
	Dehydrated ethanol	--	870	410	53
	T-I oven	5 hrs.	38	73	ris.
	T-I ethanol	5 hrs.	140	260	ris.
25	T-I oven	7 hrs.	10	16	ris.
	T-I ethanol	7 hrs.	40	100	ris.

The results show that pH 9.5-adjusted, ethanol-extracted, heat-treated tapioca and corn starches had viscosity profiles generally similar to those of the same thermally-inhibited starches which were oven-dehydrated.

The 7 hours heat-treated samples were more inhibited than the 5 hour heat-treated samples.

EXAMPLE 17

This example compares ethanol extracted granular waxy maize starches and oven-dehydrated granular waxy maize starches heat treated in an oven for 5 and 7 hours at 160°C at the same pH, i.e., pH 8.03.

The Brabender results are shown below.

		<u>Viscosity (BU)</u>		
10	<u>Dehydration/ Heat Treatment</u>	<u>Peak</u>	<u>Peak + 10'</u>	<u>Break-down (%)</u>
	Oven/None	1160	360	69
	EtOH/None	1120	370	67
	Oven/5 hrs.	510	455	11
15	EtOH/5 hrs.	490	445	9
	Oven/7 hrs.	430	395	8
	EtOH/7 hrs.	360	330	8

The thermally-inhibited starches were slurried at 6.6% solids (anhydrous basis), pH adjusted to 6.0-6.5, and then cooked out in a boiling water bath for 20 minutes. The resulting cooks were allowed to cool and then evaluated for viscosity, texture, and color.

25	<u>Dehydration Method</u>	<u>Time at 160°C</u>	<u>Viscosity</u>	<u>Texture</u>	<u>Color</u>
	Oven	None	heavy to v. heavy	cohesive	sl. off- white
	Ethanol	None	heavy to v. heavy	cohesive	sl. off- white
	Oven	5 hours	mod. heavy to heavy	non- cohesive, smooth	sl. tan, darker*
	Ethanol	5 hours	mod. heavy to heavy	non- cohesive, smooth	sl. tan

Oven	7 hours	mod. heavy non- to heavy	mod. tan, cohesive, darker* smooth
Ethanol	7 hours	mod. heavy non- to heavy	mod. tan cohesive, smooth

* Slightly darker than ethanol-dehydrated samples.

These Brabender results show that highly inhibited starches can be obtained by both thermal and non-thermal dehydration. The cook evaluation results show that there is a benefit for the ethanol-dehydrated, thermally-inhibited starches in terms of reduced color. As will be shown hereafter, there is also a flavor improvement with ethanol dehydration.

EXAMPLE 18

This example shows that alcohol dehydration provides better tasting thermally-inhibited starches.

The test performed was a "Triangle Taste Test" which employs three coded samples, two identical and one different, presented simultaneously. None of the samples is identified as the standard. Control and experimental treatments were systematically varied so that each was presented in odd and identical sample positions an equal number of times. The judge determined which of the three samples differed from the other two. A forced choice was required. Statistical analysis was used to determine whether a significant difference between treatments existed. The probability of choosing the different or odd sample by chance alone was one-third. Once the odd sample was chosen the judges were asked why the samples were different and which they preferred.

The starches tested were waxy maize starches adjusted to pH 9.5 and heat treated for 7 hours at 140°C but

one sample was dehydrated by ethanol extraction and the other sample was thermally dehydrated prior to the thermal inhibition step.

5 The thermally-inhibited starches were washed by slurring the granular starch with 1.5 parts water, mixing for 10 minutes on a stir plate, vacuum filtering the slurry, and washing the starch cake twice with 50 ml of distilled water. Then sufficient water was added to bring the slurry solids to 3%, the pH was adjusted to 6.0-6.5 and the slurry
10 was cooked 20 minutes in a boiling water bath, cooled to slightly above room temperature, and evaluated.

The judges were given 20 ml samples for tasting. They observed a significant difference between the oven-dehydrated and ethanol-dehydrated starches. Nine out of the
15 twelve judges chose the one different sample. All nine of the judges who could determine the different sample preferred the sample that was ethanol-extracted. Attributes that were used to describe the ethanol-extracted sample included clean, not bitter, and smooth compared to the oven-
20 dehydrated sample.

EXAMPLE 19

This example shows that an alcohol extraction after a granular starch is thermally-inhibited provides a better tasting starch.

25 A thermally-inhibited, granular waxy maize (adjusted to pH 9.5 and heat treated for 180 minutes in a fluidized bed at 160°C) was placed in a Soxhlet extraction apparatus and allowed to reflux overnight (about 17 hrs) using ethanol as the solvent (bp-78°C). The extracted
30 starch was then laid on paper to allow excess ethanol to flash off. The resulting dry starch was washed by slurring the starch with 1.5 parts water, mixing for 10 minutes on a stir plate, vacuum filtering the slurry, and washing the

starch cake twice with 50 ml of distilled water. Then sufficient water was added to bring the slurry solids to 3%, the pH was adjusted to 6.0-6.5, and the slurry was cooked in a boiling water bath for 20 minutes. The cook was cooled to slightly above room temperature and evaluated. The thermally-inhibited, non-ethanol-extracted base was used as the control.

The taste test performed was a "Paired-Preference Test". Two samples are presented, simultaneously or sequentially. The judge is requested to express a preference based on a specific attribute, here which sample is cleaner. Results are obtained in terms of relative frequencies of choice of the two samples as accumulated for all participants. Six of the eight trained judges identified the ethanol-extracted sample as having a blander, cleaner flavor with less aftertaste.

EXAMPLE 20

The effects of the presence of protein, and heat treating times and temperatures on inhibition on samples of waxy maize containing 3.95% endogenous protein, adjusted to pH 8.5 and 9.5, and on samples containing 1.52% endogenous protein, adjusted to pH 7.5 and 9.5, were evaluated and the results set out in the following tables. The data show that the presence of protein leads to higher levels of inhibition than are attained in samples without protein. The results also show that the protein level, the pH and the time and the temperature for heat treating all have an independent and a cumulative effect on the level of inhibition, so that inhibition increases as the protein, pH, time, and temperature increase.

	<u>Waxy Maize</u>		<u>Viscosity</u>				
	(3.95% endogenous protein/ pH 9.5)		(BU)				
			<u>Peak</u>	<u>Peak + 10'</u>	<u>92°C</u>	<u>92°C + 30'</u>	<u>Breakdown</u> (%)
5		Control	940	400			57
	<u>Temp</u> (°C)	<u>Time</u> (min)					
	125	0	--	--	660	680	ris.
10	125	30	--	--	710	750	ris.
	140	0	--	--	540	600	ris.
	160	0	--	--	350	375	ris.
	160	30	--	--	260	295	ris.
	160	60	--	--	220	275	ris.
15	160	90	--	--	180	255	ris.
	160	100	--	--	130	200	ris.
	160	120	--	--	150	210	ris.
	160	150	--	--	150	190	ris.
20	160	180	--	--	130	180	ris.
	<u>Waxy Maize</u>		<u>Viscosity</u>				
	(1.52% endogenous protein/ pH 9.5)		(BU)				
			<u>Peak</u>	<u>Peak + 10'</u>	<u>92°C</u>	<u>92°C + 30'</u>	<u>Breakdown</u> (%)
25		Control	1030	300			71
	<u>Temp</u> (°C)	<u>Time</u> (min)					
	125	0	1090	540	--	--	50
30	125	15	1080	650	--	--	40
	140	0	1010	840	--	--	17
	160	30	--	--	480	575	ris.
	160	60	--	--	340	610	ris.
	160	90	--	--	255	540	ris.
35	160	120	--	--	120	340	ris.

160 150 -- -- 120 330 ris.

	<u>Waxy Maize</u>		<u>Viscosity</u>				<u>Breakdown</u> (%)
	(3.95% endogenous protein/ pH 8.5)		<u>Peak</u>	<u>Peak + 10'</u>	<u>92°C</u>	<u>92°C + 30'</u>	
5	Control		740	235			68
10	<u>Temp</u> (°C)	<u>Time</u> (min)					
	125	0	1005	550	--	--	45
	125	15	935	700	--	--	25
	140	0	705	610	--	--	13
15	160	0	--	--	470	480	ris.
	160	30	--	--	380	455	ris.
	160	60	--	--	290	430	ris.
	160	90	--	--	235	410	ris.
	160	120	--	--	210	380	ris.
20	<u>Waxy Maize</u>		<u>Viscosity</u>				<u>Breakdown</u> (%)
	(1.52% endogenous protein/ pH 7.6)		<u>Peak</u>	<u>Peak + 10'</u>	<u>92°C</u>	<u>92°C + 30'</u>	
25	Control		1100	240			78
30	<u>Temp</u> (°C)	<u>Time</u> (min)					
	125	0	1230	480	--	--	--
	140	0	950	730	--	--	23
	140	0	660	570	--	--	14
35	160	30	535	505	--	--	6
	160	60	--	--	480	415	ris.
	160	90	--	--	490	430	ris.
	160	120	--	--	465	435	ris.
	160	150	--	--	435	420	ris.

EXAMPLE 21

This example describes the effect of the removal of various proteins, lipids, and other off flavor components on the flavor (i.e., taste and aroma) of a thermally-inhibited waxy maize.

Prior to the thermal inhibition process (i.e., solvent extraction or freeze drying and heat treatment), the protein is extracted from a waxy maize starch as follows. The starch is slurried at W=1.5 (50 lbs starch to 75 lbs of water) and the pH is adjusted to 3-3.5 with sulfuric acid. Sodium chlorite is added to give 2% on the weight of the starch. The starch is steeped overnight at room temperature. The pH is raised to about 9.5 using a 3% sodium hydroxide solution and washed well prior to drying. The protein level of the starch is reduced to about 0.1%. The protein level of an untreated waxy maize control (pH 9.5) is about 0.3%.

This treatment should improve the flavor of the thermally-inhibited granular starches prepared using the non-thermal dehydration methods since the same treatment of a thermally-inhibited granular starch prepared using thermal dehydration improved the flavor as reported below. Removal of various proteins, lipids, and other off flavor components is expected to improve the flavor of all starch bases and flours.

Using a one-sided, directional difference taste testing procedure, as described in "Sensory Evaluation Techniques" by M. Meilgaard et al., pp. 47-111 (CRC Press Inc., Boca Raton, Florida 1987), the protein-reduced thermally-inhibited waxy maize (adjusted to pH 9.5; dehydrated and heat treated for 90 min at 160°C in a fluidized bed) was compared to the thermally-inhibited waxy

maize (pH 9.5; 160°C/90 min) which had not been protein-reduced prior to heat treatment.

For the taste test, 3% starch cooks (samples heated at 100°C for 15 min) were prepared and panelists were asked to select which sample was "cleaner" in flavor. All tests were done in a sensory evaluation room under red lights in order to negate any color differences that may have been present between samples. The results are shown below:

10

<u>Trial #</u>	<u>Number of Panelists</u>	<u>Number of Positive Responses¹</u>	<u>Significance Level (α risk)²</u>
1	15	12	5%
2	14	11	5%

15

¹ The number indicates those respondents who selected the protein-reduced product as being cleaner in flavor.

² The α values were determined from a statistical table. An α risk of 5% indicates (with 95% confidence) that the samples are statistically different, i.e., that the protein-reduced product is cleaner than the control.

20

EXAMPLE 22

A granular waxy maize starch was pH adjusted to pH 9.5 as previously described. The starch was then placed in a freeze dryer and dried for 3 days until it was anhydrous (0% moisture). The freeze-dried (FD) starch was heat treated for 6 and 8 hours at 160°C in a forced draft oven.

Brabender evaluations were run. The results are shown below:

	<u>Waxy Maize (pH 9.5)</u>	<u>Time at 160°C</u>	<u>Viscosity (BU)</u>		<u>Break-down (%)</u>
			<u>Peak</u>	<u>Peak + 10'</u>	
35	Control	--	1260	320	75

		<u>Viscosity (BU)</u>		
F.D.	--	1240	320	74
T-I	6 hrs.	340	465	ris.
T-I	8 hrs.	285	325	ris.

5 The results show that the starch can be dehydrated by freeze drying and that the subsequent heat treatment is necessary to inhibit the starch. The starches are highly inhibited as shown by their rising viscosity.

EXAMPLE 23

10 This example shows that thermal inhibition reduced the gelatinization temperature of the granular waxy maize starches.

 The gelatinization temperature of an untreated waxy maize, a thermally-inhibited (T-I) waxy maize (pH adjusted and not pH adjusted), and chemically-crosslinked (X-linked) waxy maize starches (0.02%, 0.04%, and 0.06% phosphorus oxychloride) were determined by Differential Scanning Calorimetry. The starches were thermally dehydrated and heat treated in an oven for the indicated time and temperature.

 The peak gelatinization temperature and enthalpy (ΔH) are shown below.

<u>Waxy Maize</u>		<u>Peak Gelatinization Temperature (°C)</u>	<u>Enthalpy (cal/g)</u>
25	Unmodified	74	4.3
	T-I (pH 9.5; 160°C for 8.5 hrs.)	68	2.9
30	T-I Waxy Maize (pH 6; 160°C for 8 hrs.)	59	2.8

	X-linked (0.02% POCl ₃)	73	4.4
	X-linked (0.04% POCl ₃)	72	4.2
5	X-linked (0.06% POCl ₃)	74	4.2

The results show that there was a significant reduction in peak gelatinization temperature of the thermally inhibited (T-I) starches. The heat treatment reduced the enthalpy (ΔH) from 4.3 cal/g for the unmodified starch to 2.8 - 2.9 cal/g for the thermally-inhibited starch. The chemically crosslinked (X-linked) starches are essentially identical to the unmodified waxy starch in peak temperature (72-74°C vs. 74°C) and enthalpy (4.2-4.4 vs 4.3 cal/g). The reduced gelatinization temperature suggests that the overall granular structure has been altered by the dehydration and heat treatment.

EXAMPLE 24

This example shows that the thermal inhibition may begin as early as 110°C (230°F), that it is substantially noticeable at 160° (320°F), and that the gelatinization is unchanged or reduced. Granular waxy maize starches were pH adjusted to 7.0 and 9.5 and dehydrated and heat treated using air having a Dew point below 9.4°C (15°F) in the fluidized bed previously described at the indicated temperature and time. The Brabender and DSC results are shown below.

30 Waxy Maize (pH 7.0)

Dehydration/
Heat Treatment
Conditions

Brabender Viscosity (BU)

Peak

Peak + 10'

Breakdown
(%)

	Control*	1010	220	78.2
	93°C for 0 min.	1010	220	78.2
	116°C for 0 min.	1030	250	75.7
	127°C for 0 min.	1050	260	75.2
5	149°C for 0 min.	1130	350	69.0
	160°C for 0 min.	1010	590	41.6
	160°C for 10 min.	980	630	35.7
	160°C for 20 min.	910	610	33.0
	160°C for 80 min.	750	510	32.0
10	160°C for 90 min.	735	510	30.6

* Not pH-adjusted.

	Dehydration/ Heat Treatment <u>Conditions</u>	Peak Gelatinization <u>Temperature**</u>	<u>Enthalpy** (cal/g)</u>
	Control	73.07	4.43
	93°C for 0 min.	71.79	4.01
20	116°C for 0 min.	70.70	4.18
	127°C for 60 min.	70.66	4.07
	149°C for 90 min.	70.07	3.92
	160°C for 0 min.	69.50	4.08
	160°C for 10 min.	71.20	4.17
25	160°C for 20 min.	68.87	4.32
	160°C for 80 min.	67.84	4.35
	160°C for 90 min.	67.29	4.38

* Average of 2 readings.

30 ** Not pH-adjusted.

Waxy Maize (pH 9.5)

	Dehydration/ Heat Treatment Conditions	Brabender Viscosity (BU)		
		<u>Peak</u>	<u>Peak + 10'</u>	<u>Breakdown (%)</u>
5	Control (pH 9.5)	1240	300	75.8
	93°C for 0 min.	1200	300	75.0
	104°C for 0 min.	1205	320	73.4
	110°C for 0 min.	1260	400	68.3
	121°C for 0 min.	1230	430	65.0
10	127°C for 0 min.	1255	420	66.5
	138°C for 0 min.	1245	465	62.7
	149°C for 0 min.	1300	490	62.3
	160°C for 0 min.	1120	910	18.8
	160°C for 60 min.	750	730	2.7
15	160°C for 90 min.	690	680	1.4
	Dehydration/ Heat Treatment Conditions	Peak Gelatinization Temperature	Enthalpy (cal/g)	
	Control (pH 9.5)	74.82	4.05	
20	127°C for 0 min.	74.84	4.17	
	160°C for 0 min.	73.04	4.50	
	160°C for 60 min.	71.84	4.60	
	160°C for 90 min.	70.86	4.26	
25	* Average of 2 readings.			

The DSC results show that at the onset of inhibition there was a slight reduction in the peak gelatinization temperature and that as the inhibition temperature and time increased there was a reduction in peak gelatinization temperature.

EXAMPLE 25

This example shows the correlation between the RVA pasting temperature and time and DSC peak gelatinization temperature and time and the reduction in Brabender viscosity breakdown for various granular starch bases and for granular waxy maize starches dehydrated by various methods including heating, ethanol extraction, and freeze drying. The base starches were unmodified. The starches were all adjusted to pH 9.5 before dehydration. The ethanol-extracted and freeze-dried controls were pH adjusted and dehydrated but not heat treated. The dehydrated starches were all heat treated in an oven at 160°C for the indicated time except for the starches chemically crosslinked with sodium trimetaphosphate (STMP) which were heat treated at 160°C for the indicated time in the fluidized bed previously described.

The results are shown below.

	<u>Starch</u>	<u>Pasting</u>		<u>DSC</u>		<u>Viscosity (B.U.)</u>		
		<u>Temp.</u> (°C)	<u>Time</u> (min)	<u>Peak Temp.</u> (°C)	<u>Time</u> (min)	<u>Peak</u>	<u>Peak +10'</u>	<u>Break down</u> (%)
20	<u>Tapioca Control</u>	68.20	3.7	70.61	6.6	1595	440	72.41
<u>Dehydrated Thermally/Heat Treated at 160°C</u>								
25	T-I (2 hrs.)	66.65	3.4	68.31	6.3	1230	560	54.47
	T-I (6 hrs.)	64.20	2.9	65.41	6.0	355	335	5.63
	<u>Potato Control</u>	61.05	2.3	62.67	5.8	1825	1010	44.66
30	<u>Dehydrated Thermally/Heat Treated at 160°C</u>							
	T-I (3 hrs.)	60.25	2.1	61.41	5.6	995	810	18.59
	T-I (6 hrs.)	60.20	2.1	61.13	5.6	ris.	ris.	ris.

	Waxy Maize <u>Control</u>	70.95	4.3	73.86	6.9	1215	350	71.79
	<u>Dehydrated Thermally/Heat Treated at 160°C</u>							
5	T-I (8 hrs.)	68.15	3.7	70.71	6.6	760	720	5.26
	Waxy Maize <u>Control</u>	70.95	4.3	74.23	6.9	1250	400	68.00
10	<u>Ethanol Dehydrated/Heat Treated at 160°C</u>							
	T-I (2 hrs.)	65.00	3.1	71.81	6.7	ris.	ris.	ris.
	T-I (7 hrs.)	63.85	2.8	68.12	6.3	ris.	ris.	ris.
15	Waxy Maize <u>Control</u>	71.30	4.4	74.16	6.9	1240	320	74.19
	<u>Dehydrated by Freeze Drying/Heat Treated at 160°C</u>							
20	T-I (6 hrs.)	69.50	4.0	66.09	6.1	ris.	ris.	ris.
	T-I (8 hrs.)	66.75	3.5	64.64	6.0	ris.	ris.	ris.
25	Cross- linked Waxy Maize <u>Control</u>	71.70	N.D.	74.33	6.9	ris.	ris.	ris.
	<u>Thermally Dehydrated Crosslinked Waxy Maize*</u>							
30	T-I (30 min.)	69.10	N.D.	71.66	6.7	ris.	ris.	ris.
	T-I (150 min.)	66.00	N.D.	67.14	6.2	ris.	ris.	ris.
35	* Fluidized bed.							

The results show that heat treatment of thermally and non-thermally dehydrated granular starches reduced the

pasting and peak gelatinization temperatures while at the same time inhibiting the viscosity breakdown. Because the gelatinization temperature has been lowered by the heat treatment of the dehydrated starch, less time is required to reach the pasting and gelatinization temperatures. The more highly inhibited starches showed a lower pasting temperature and less breakdown in viscosity.

EXAMPLE 26

This example describes a visual evaluation of the dry powder flow properties of granular waxy maize starches adjusted to pH 9.5 and thermally dehydrated and heat treated in the fluidized bed previously described.

The starches evaluated are shown below:

<u>No.</u>	<u>Heat Treatment Conditions</u>
1	160°C for 30 min.
2	160°C for 60 min.
3	160°C for 180 min.

Powder No. 1 distributed fairly evenly and the flow pattern was uniform. It was somewhat fluid and had some dynamic quality. Only a slight amount of air was entrapped in the body of the powder. Powder No. 2 distributed evenly and the flow pattern was uniform. The powder was fluid and had a dynamic quality. There was no air entrapment in the body of the powder. Powder No. 3 distributed evenly and the flow pattern was uniform. The powder was fluid, water-like, and had a dynamic quality. No air was entrapped in the body of the powder. The control starch powder clumped and had an irregular flow. It had a cake-like static quality. Air was entrapped in the body of the powder.

EXAMPLE 27

This example measures the flow properties of thermally-inhibited waxy maize starches by determining the angle of repose which is an indication of performance with regard to mobility/flow. The starches were adjusted to pH 9.5 and thermally inhibited by dehydration and heat treatment in the fluidized bed previously described.

The results are shown below:

	<u>Heat Treatment Conditions</u>	<u>Angle of Repose *</u>
10	160°C for 30 min.	24.17
	160°C for 60 min.	26.75
	160°C for 180 min.	23.60

15 * Average of 5 readings.

The thermally-inhibited starches had good flow properties. The control did not flow. A chemically crosslinked and derivatized waxy corn starch also did not flow. The funnels were completely blocked upon addition of the sample. This starch would not even flow through powder funnels with larger internal diameter orifices without constant tapping. Similar results, i.e., no flow, were observed with native corn starch.

25 EXAMPLE 28

The following example shows the wet particle size of waxy maize starches adjusted to pH 9.5 and dehydrated and heat treated in the fluidized bed previously described.

	<u>Starch</u>	<u>Heat Treatment Conditions</u>	<u>Wet Particle Size *</u> (microns)
30	Control		15.198
35	T-I	160°C for 0 min.	17.029
	T-I	160°C for 90 min.	19.251
	T-I	169°C for 180 min.	18.880

The result shows that the thermally-inhibited starches swell more than the uninhibited control. As the starch became more highly inhibited, the swelling was somewhat reduced but the starch was still more swollen than the control. This increased swelling indicates that the thermally-inhibited starches would be useful as tablet disintegrants.

EXAMPLE 29

This example shows that the thermally-inhibited starches and flours are substantially sterilized by the dehydration heat treatment in the fluidized bed. This property is useful in all pharmaceutical applications.

The testing was done according to the methods described in The United States Pharmacopeia (USP 23), The National Formulary (NF 18) dated January 1, 1995, which is the procedure described at pages 17-19 of Chapter 3 "Aerobic Plate Count" by J.T. Peeler and L.J. Maturin, F.D.A. Bacteriological Analytical Manual, 7th Edition A.D.A.C. International, Arlington, Va. (1992). The starches were tested for the presence of Coliform, Salmonella, yeast and molds, Staphylococcus aureus, Escherichia coli, and Pseudomonas aeruginosa. The total plate count at 32°C was determined and any organisms were identified.

PART A - Thermally-Inhibited Waxy Rice Flour

The flour was adjusted to pH 9.5, heat treated under the conditions shown below, and stored for about 3 months in non-sterilized, covered glass containers.

The results are shown below.

<u>Heat Treatment</u>	<u>Plate Count</u> (CFU)*
None	7500
160°C for 0 min.	<10

160°C for 60 min. <10

160°C for 120 min. <10

5 * Colony forming units.

PART B - Thermally-Inhibited Waxy Maize Starch

The starch was adjusted to pH 9.5, and thermally-
 10 inhibited under the conditions shown below, and stored for
 about 2 months in non-sterilized, covered glass containers.
 The thermally-inhibited starches and the control starch were
 microbiologically tested for their total plate count and the
 presence of organisms using the above procedure.

15 The results are shown below.

		Plate Count Colony Forming Units (CFU) *
20	None	2000
	160°C for 60 min.	<10
25	160°C for 60 min. sample	<10
	160°C for 120 min. sample)	<10
30	* Colony forming units.	

Coliform, Salmonella, yeast and molds,
 Staphylococcus aureus, Escherichia Coli, and Pseudomonas
 aeruginosa were not present. A reading of <10 CFU means
 35 there is essentially nothing measurable. The above results
 are particularly surprising, especially since the thermally-
 inhibited flours and starches were not handled using aseptic
 techniques. If stored and maintained under sterile
 conditions, these starches should be useful in products
 40 where microbiological considerations are of concern.

EXAMPLE 30

Waxy maize samples, crosslinked with phosphorus oxychloride POCl_3 , at 0.02% by weight, at naturally occurring pH and at pH 9.5 were evaluated for inhibition and the results set out in the following tables. The data show decreasing viscosity and almost no breakdown in viscosity with longer heat treating times, indicating that crosslinked starches can be made even more inhibited by this process. The data also show that increasing the pH further increases inhibition.

<u>Waxy Maize</u> (POCl ₃ Natural pH)		<u>Viscosity</u> (BU)				
		<u>Peak</u>	<u>Peak</u> <u>+ 10'</u>	<u>92°C</u>	<u>92°C</u> <u>+ 30'</u>	<u>Breakdown</u> (%)
	Control	830	820			1
15	<u>Temp</u> (160°C)	<u>Time</u> (min)				
	0	750	742	730	720	1
	30	635	522	630	580	2
	60	550	525	550	465	5
20	90	425	415	420	360	2
	120	335	315	330	280	6
	150	280	260	280	210	7
	180	205	200	200	180	2

25

<u>Waxy Maize</u> (POCl_3 pH 9.5)	<u>Viscosity</u> (BU)				<u>Breakdown</u> (%)
	<u>Peak</u>	<u>Peak</u> <u>+ 10'</u>	<u>92°C</u>	<u>92°C</u> <u>+ 30'</u>	
Control	830	820			1

	<u>Temp</u> (160°C)	<u>Time</u> (min)					
5		0	750	720	---	---	4
		30	---	---	630	660	ris.
		60	---	---	400	635	ris.
		90	---	---	330	520	ris.
		120	---	---	180	530	ris.
		150	---	---	110	470	ris.
		180	---	---	100	470	ris.

10

EXAMPLE 31

This example shows the thermal inhibition of converted starches.

Samples of waxy maize and tapioca starch were slurried in 1.5 parts water. The slurries were placed in a 52°C water bath, with agitation, and allowed to equilibrate for one hour. Concentrated hydrochloric acid (HCl) was added at 0.8% on the weight of the samples. The samples were allowed to convert at 52°C for one hour. The pH was then adjusted to 5.5 with sodium carbonate, then to pH 8.5 with sodium hydroxide. The samples were recovered by filtering and air drying (approximately 11% moisture). The starches in 50g amounts were placed in an aluminum tray, covered and placed into a forced draft oven at 140°C for 5.5 hours. The starches were evaluated for inhibition.

The results set out in the following table.

	<u>Waxy Maize</u>			<u>Tapioca</u>		
	<u>Viscosity (BU)</u>			<u>Viscosity (BU)</u>		
	<u>Peak</u>	<u>Peak + 10'</u>	<u>Break-down (%)</u>	<u>Peak</u>	<u>Peak + 10'</u>	<u>Break-down (%)</u>
unmodified	1380	250	81.9	810	225	72.2
acid converted	640	110	82.3	432	115	73.4

T-I acid 805 728 9.6 495 350 29.3
converted

The results show that converted starches can be
5 thermally inhibited by this process.

EXAMPLE 32

This example describes the preparation of a thermally-inhibited enzyme-converted starch.

A total of 1.5 kg of a thermally-inhibited waxy maize
10 starch (pH 9.5; heated at 160°C for 100 minutes in the fluidized
bed previously described) is slurried in 4.5 liters of water.
The pH of the slurry is then adjusted to 4.5 using dilute
hydrochloric acid. the temperature of the mixture is then raised
to 55°C and 75 g. of glucoamylase is added. The mixture is
15 stirred until the desired degree of reducing sugar is produced,
for example, 23 DE (Dextrose Equivalent), the pH of the mixture
is adjusted to 9.5 using dilute sodium hydroxide and held for 30
minutes to inactivate the enzyme. It is then readjusted to pH
6.0-7.0 with dilute hydrochloric acid, recovered by filtration,
20 washing and drying. Alternatively, the reaction mixture can be
recovered directly by spray drying without the purification step.

EXAMPLE 33

Waxy maize samples reacted with 7% and at 3% by weight
propylene oxide (PO), at the naturally occurring pH and at pH
25 9.5, were evaluated for inhibition.

The results set out in the following tables.

Viscosity (BU)

	<u>Temp</u> (°C)	<u>Time</u> (min)	<u>Peak</u>	<u>Peak +</u> <u>10'</u>	<u>92°C</u>	<u>92°C +</u> <u>30'</u>	<u>Breakdown</u> (%)
30	<u>Waxy Maize (7% PO and natural pH at 160°C)</u>						
	Control	--	1420	395	--	--	72
	160	0	1030	380	--	--	63

	160	30	800	530	--	--	34
	160	60	685	430	--	--	37
	160	90	635	340	--	--	46
	160	120	620	340	--	--	45
5	160	150	565	300	--	--	47
	160	180	540	280	--	--	48
<u>Waxy Maize (7% PO and pH 9.5 at 160°C)</u>							
	Control	--	1420	395	--	--	72
	160	0	1360	960	--	--	29
10	160	30	1010	950	--	--	6
	160	60	1030	930	--	--	10
	160	90	910	890	--	--	2
	160	120	843	830	--	--	2
	160	180	800	792	--	--	1
15	<u>Waxy Maize (3% PO and natural pH at 160°C)</u>						
	Control	--	1155	280	--	--	76
	160	0	900	360	--	--	60
	160	30	570	370	--	--	35
	160	60	480	350	--	--	27
20	160	90	440	300	--	--	32
	160	120	375	235	--	--	37
	160	150	310	185	--	--	40
	160	180	300	180	--	--	40
<u>Waxy Maize (3% PO and pH 9.5 at 160°C)</u>							
25	Control	--	1155	280	--	--	76
	160	0	1220	960	--	--	21
	160	30	1020	950	--	--	7
	160	60	880	865	--	--	2
	160	90	--	--	750	790	ris.
30	160	120	--	--	620	780	ris.

160	150	--	--	510	750	ris.
160	180	--	--	400	700	ris.

The data show that derivatized starches, in this case
 5 etherified starches, can be thermally inhibited by this process
 and that higher inhibition can be achieved at higher pH.

EXAMPLE 34

A converted hydroxypropylated waxy maize starch (25 WF
 starch reacted with 2% propylene oxide) was adjusted to pH 9.5
 10 and thermally inhibited using the fluidized bed previously
 described. Samples were taken at 110°C, 125°C, and 140°C, all
 for 0 minutes.

The thermally-inhibited starch samples were cooked in
 tap water at 88-93°C (190-200°F) bath temperature for 30-60
 15 minutes to yield solutions having a Brookfield viscosity of
 approximately 3000 cps. The viscosity stability at room
 temperature was evaluated. The control was a hydroxy-propylated
 waxy maize starch which was not thermally-inhibited.

The results are tabulated below.

20		<u>Solution Stability</u>			
		<u>Control</u>	<u>110°C</u>	<u>125°C</u>	<u>140°C</u>
	Water Fluidity	25.0	25.5	20.6	21.8
	Solids (%)	18	18	18	18
	Initial	3160	2550	2820	2800
25	Viscosity (cps)				
	Viscosity after 24 hours (cps)	3280	--	--	2640
	Viscosity after 7 days (cps)	3020	2475	2730	2810
30	Viscosity after 8 days (cps)	3000	1980	2140	2940
	Viscosity after 9 days (cps)	2850	1990	2230	2870
	Appearance	clear	clear	clear	yellow

EXAMPLE 35

Waxy maize samples at the naturally occurring pH and at pH 8.5, were reacted with 1% by weight acetic anhydride (Ac_2O) and thermally-inhibited. The control was the non-thermally-inhibited waxy maize starch acetate.

The results are shown below.

		<u>Viscosity (BU)</u>					<u>Break-</u>
		<u>Time</u>	<u>Peak</u>	<u>Peak +</u>	<u>92°C</u>	<u>92°C +</u>	<u>down</u>
		<u>(min)</u>		<u>10'</u>		<u>30'</u>	<u>(%)</u>
<u>Waxy Maize (1% Ac₂O and natural pH at 160°C)</u>							
10	Control	--	1480	490	--	--	67
		0	1030	570	--	--	45
		30	880	650	--	--	26
		60	720	510	--	--	29
		120	605	490	--	--	19
15		180	545	460	--	--	16
<u>Waxy Maize (1% Ac₂O and natural pH at 160°C)</u>							
20	Control	--	1480	490	--	--	67
		0	1170	560	--	--	52
		30	970	725	--	--	25
		60	875	600	--	--	31
		120	690	490	--	--	29
		180	585	545	--	--	7

The data show that derivatized starches, in this case esterified starches, can be inhibited to varying degrees and that higher inhibition can be obtained at higher pH.

EXAMPLE 36

This example shows the preparation of a thermally-inhibited cationic starch.

A granular waxy corn starch (1000 g) was slurried in 1500 cc water, 175 g of 4% sodium hydroxide were added, and the

slurry was heated to 40°C. One hundred (100) g of a 50% aqueous solution of 3-chloro-2-hydroxypropyl trimethyl ammonium chloride was added while maintaining the pH at 11.5 by adding 4% sodium hydroxide. The mixture was allowed to react overnight at 40°C.

5 The slurry was adjusted to pH 6.5 with hydrochloric acid, filtered, washed and air dried to about 8-15% moisture. The degree of substitution was of 0.04.

A portion of the above cationic starch derivative was chemically crosslinked with 0.01 wt. % of epichlorohydrin at 40°C
10 for 16 hours, neutralized to pH 6.0, filtered, water washed (2 parts water per part of starch), and air dried to about 8-15% moisture.

A portion of the above chemically-crosslinked, cationic starch was thermally inhibited by adjusting the pH to 9.5 with a
15 5% solution of sodium carbonate, spray-drying without gelatinization to between 3-15% moisture, and thermally dehydrating and heat treating the cationic, chemically-crosslinked granular starch in the fluidized bed previously described.

20 The starch samples were slurried at 4-6% solids and cooked in a mini-jet cooker (scaled down jet cooker to simulate a commercial jet cooker) at a temperature of 105-122°C and an applied back pressure of 5-20 psi using controlled live steam. The mini-jet cooker had a cooking chamber capacity or volume of
25 5.0 ml. The starch was passed through the cooking chamber at a flow rate of about 130 ml/min with a retention time of about 2.3 seconds.

The samples of starches were tested for Brookfield viscosity at 3% solids at 20 rpm with a No. 5 spindle.

30 Brookfield Viscosity (cps)

Control	300
T-I Chemically Crosslinked	3650

	T-I (120°C for 0 min.)	440
	T-I (125°C for 15 min.)	790
	T-I (130°C for 0 min.)	990
	T-I (160°C for 0 min.)	1900
5	T-I (160°C for 30 min.)	<60
	T-I (160°C for 120 min.)	<60

The results show that the thermally-inhibited starches are much lower in viscosity (<60 to 1900 cps) than the thermally-inhibited chemically crosslinked starch (3650 cps.). This is a significant advantage in some end uses.

A Brabender analysis run on the starch which thermally inhibited at 160°C for 120 minutes. It showed a percentage breakdown of 2%.

15

EXAMPLE 37

This example shows the preparation of potato starches modified with an amino-multicarboxylic acid (CEPA) reagent, i.e., 2-chloroethylaminodipropionic acid (hereinafter referred to as CEPA-starches) and their subsequent thermal-inhibition.

20

Deionized water (150 ml) was added to a liter beaker and heated to 45°C with an external constant temperature bath. A total of 30 g sodium sulfate (30% on starch) was dissolved in the water followed by the addition of 100 g of the potato starch. A solution of 3% aqueous sodium hydroxide (25 ml) was added slowly with good agitation to minimize starch swelling. A 25% aqueous solution of the CEPA reagent (32 ml) to give an 8% starch treatment (dry basis was added simultaneously with a 3% aqueous sodium hydroxide solution (170 ml). The addition rates used kept the level of caustic high so that pH was about 11.0 to 11.5 during the reaction. The reaction was run at 42-45°C for 16 hours and then neutralized by adding 3 N hydrochloric acid to adjust pH to about 9.5, followed by stirring for 30 minutes.

Overhead stirring was used throughout this reaction. The starch was then filtered and washed twice with 150 ml of water and allowed to air dry. Analysis of the starch for bound nitrogen showed 0.25% N (dry basis).

5 The pH 9.5 CEPA-starch was heat treated at 100°C, 110°C, 120°C, 130°C, and 140°C for 0 minutes using the fluidized bed previously described.

EXAMPLE 38

10 This example describes the preparation of a barbecue sauce containing a thermally inhibited waxy maize starch at its naturally occurring pH (pH 6), heat treated at 160°C for 150 minutes (T-I starch). The ingredients in percent by weight are as follows:

15	T-I starch	2.5%
	sugar	3.0
	salt	0.3
	paprika	0.2
	chili powder	0.2
	cinnamon	0.2
20	ground cloves	0.2
	tomato puree	47.4
	minced onion	5.3
	Worcestershire sauce	6.6
	water	26.2
25	vinegar	7.9
	TOTAL	100.0

30 The sauce is heated to 85°C, held for 15 minutes, and cooled overnight at room temperature. The sauce will have a smooth, non-cohesive texture.

 Now that the preferred embodiments of the invention have been described in detail, various modifications and improvements thereon will become readily apparent to the practitioner. Accordingly, the spirit and scope of the present invention are to be limited only by the appended claims, and not
35 by foregoing specification.

WHAT IS CLAIMED IS:

1. A thermally-inhibited, non-pregelatinized granular starch or
5 flour.
2. The starch or flour of Claim 1, characterized in that the
starch or flour has an unchanged or reduced gelatinization
temperature.
- 10 3. The starch or flour of Claim 1, characterized in that an
aqueous dispersion of the cooked starch or flour has improved
viscosity stability and a non-cohesive texture in comparison to
the non-thermally-inhibited base starch or flour.
- 15 4. The starch or flour of Claim 1, characterized in that the
starch or flour has an unchanged or reduced gelatinization
temperature and characterized in that an aqueous dispersion of
the cooked starch or flour has improved viscosity stability and a
20 non-cohesive texture in comparison to the non-thermally-inhibited
base starch or flour.
5. The starch or flour of Claim 1, wherein the starch is a
cereal, root, tuber, legume, or fruit starch.
- 25 6. The starch or flour of Claim 5, wherein the starch is
selected from the group consisting of banana, corn, pea, potato,
sweet potato, barley, wheat, rice, sago, amaranth, tapioca,
sorghum, V.O., waxy maize, waxy pea, waxy wheat, waxy tapioca,
30 waxy rice, waxy barley, waxy potato, waxy sorghum, and a starch
or flour containing greater than 40% amylose.

7. The starch or flour of Claim 1, wherein the starch or flour is a modified starch or flour.

8. The starch of Claim 7, wherein the starch is a derivatized starch, a converted starch, a chemically crosslinked starch, a derivatized and converted starch, a derivatized and chemically crosslinked starch, or a converted and chemically crosslinked starch.

9. The starch of Claim 7, wherein the starch is derivatized by reaction with an etherifying or an esterifying reagent.

10. The starch of Claim 7, wherein the starch is an acid-, enzyme-, and/or heat-converted starch.

11. The starch or flour of Claim 7, wherein the flour is bleached and/or enzyme-converted.

12. A dehydrated and subsequently heat treated non-pregelatinized granular starch or flour.

13. A process for making a thermally-inhibited, non-pregelatinized granular starch or flour, which comprises the steps of:

- (a) dehydrating the starch or flour to anhydrous or substantially anhydrous, and
- (b) heat treating the anhydrous or substantially anhydrous starch or flour at a temperature and for a time sufficient to inhibit the starch or flour.

14. The process of Claim 13, wherein the dehydrating step is a thermal dehydrating step and/or a non-thermal dehydrating step.

15. The process of Claim 13, wherein the thermal dehydrating step is carried out in a fluidized bed.

5 16. The process of Claim 13, wherein the non-thermal dehydrating step is carried out by freeze drying the starch or flour or by extracting the starch or flour with a solvent.

17. The process of Claim 16, wherein the solvent is a hydrophilic solvent.

10

18. The process of Claim 17, wherein the hydrophilic solvent forms an azeotrope with water.

19. The process of Claim 18, wherein the solvent is an alcohol.

15

20. The process of Claim 13, wherein the heat treating step is carried out at a temperature of 100°C or greater.

20

21. The process of Claim 20, wherein the heat treating step is carried out at a temperature of about 120-180°C for up to about 20 hours.

25

22. The process of Claim 13, which further comprises the step of adjusting the pH of the non-pregelatinized granular starch to neutral or greater prior to the dehydrating step.

23. The process of Claim 22, wherein the pH is about 7-9.5.

30

24. The process of Claim 13, further comprising the step of extracting the heat-treated starch or flour with an organic solvent to improve the flavor and/or color of the starch or flour.

25. The process of Claim 23, wherein the solvent is ethanol.

26. The process of Claim 13, further comprising the step of washing the starch or flour with water prior to the dehydrating
5 step and/or after the heat treating step.

27. The process of Claim 13, further comprising the step of removing protein and/or lipid from the starch or flour prior to the dehydrating step and/or after the heat treating step.
10

28. The process of Claim 27, wherein a bleaching agent is used to remove the protein and/or lipid.

29. The process of Claim 28, wherein the bleaching agent is sodium chlorite.
15

30. The process of Claim 27, wherein an alkali is used to remove the protein and/or lipid.

31. The process of Claim 22, wherein the pH is about 9.5 and wherein the dehydrating step and heat treating steps are carried out in a fluidized bed at a temperature of about 120-160°C for up to 20 hours.
20

Abstract

Thermally-inhibited starches and flours which are functionally equivalent to chemically-crosslinked starches are prepared by a process which comprises the steps of dehydrating a granular starch or flour to anhydrous or substantially anhydrous (< 1% moisture) and heat treating the dehydrated starch or flour for a time and at a temperature sufficient to inhibit the starch, (e.g., 120-180°C for up to 20 hours). Preferably the pH of the starch is adjusted to neutral or greater (e.g., pH 8-9.5) prior to the dehydration. The dehydration may be a thermal dehydration carried out simultaneously with the heat treatment or a non-thermal dehydration carried out by extraction with a solvent (e.g., ethanol) or by freeze drying.

15

As a below named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated below next to my name.

I believe that I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled THERMALLY-INHIBITED NON-PREGELATINIZED GRANULAR STARCHES AND FLOURS AND PROCESS FOR THEIR PRODUCTION the specification of which

(check one) ☐ is attached hereto
☒ was filed on January 29, 1996 as
 Application Serial No. 08/593,022
 and was amended on _____ (if applicable).

I hereby state that I have reviewed and understand the contents of the above identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose information which is material to the examination of this application in accordance with Title 37, Code of Federal Regulations, §1.56(e).

I hereby claim foreign priority benefits under Title 35, United States Code, §119 of any foreign application(s) for patent or inventor's certificate listed below and have also identified below any foreign application for patent or inventor's certificate having a filing date before that of the application on which priority is claimed:

Prior Foreign Application(s)	Priority Claimed
<u>PCT/US94/08559</u> (Number)	<u>PCT</u> (Country)
<u>20 July 1994</u> (Day/Month/Year Filed)	<input checked="" type="radio"/> Yes <input type="radio"/> No
<u> </u> (Number)	<u> </u> (Country)
<u> </u> (Day/Month/Year Filed)	<input type="radio"/> Yes <input type="radio"/> No
<u> </u> (Number)	<u> </u> (Country)
<u> </u> (Day/Month/Year Filed)	<input type="radio"/> Yes <input type="radio"/> No

I hereby claim the benefit under Title 35, United States Code, §120 of any United States application(s) listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States application in the manner provided by the first paragraph of Title 35, United States Code, §112, I acknowledge the duty to disclose material information as defined in Title 37, Code of Federal Regulations, §1.56(a), which occurred between the filing date of the prior application and the national or PCT international filing date of this application:

<u>08/098,753</u> (Application Serial No.)	<u>30 July 1993</u> (Filing Date)	<u>Abandoned</u> (Status-patented, pending, abandoned)
<u>08/296,211</u> (Application Serial No.)	<u>25 August 1994</u> (Filing Date)	<u>Pending</u> (Status-patented, pending, abandoned)
<u>08/374,279</u> (Application Serial No.)	<u>18 January 1995</u> (Filing Date)	<u>Pending</u> (Status-patented, pending, abandoned)
<u>08/473,688</u> (Application Serial No.)	<u>07 June 1995</u> (Filing Date)	<u>Pending</u> (Status-patented, pending, abandoned)

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